

Lastek 236 C

Plastic moulds

CLASSIFICATION

EN ISO 14700 : S Fe8
DIN 8555 : WSG 6-GZ-60

GENERAL DESCRIPTION

Lastek 236C is a hard facing rod with a very good wear and shock resistance. This alloy lends itself perfectly to repair small defects. Multiple welding beads are possible without fissuring. The deposited weld metal can be mirror finished.

APPLICATIONS

Repair and fabrication of plastic moulds, cold working cutting tools and dies, etc....

Hardness: 50 - 60 HRC.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 0.40 - 0.50	Mn : 0.30 - 0.60	Si : 2.80 - 3.20	Cr : 9.00 - 9.50	P : < 0.025
S : < 0.02	Cu : < 0.25	Ni : < 0.15	V : < 0.03	Al : < 0.03

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

GENERAL INFORMATION

Welding positions	All	
Shielding gas	Argon	
Packing	5 kg in a cardboard box	
Polarity	DC, with the torch on the negative pole.	
Diameter (mm)	1.6	2.0
Length (mm)	1000	1000

Tips & tricks Clean the weld area thoroughly. Remove cracks and sharp radii by grinding. Preheat and post-heat will be dictated by the base metal tempering temperature and dimensions. Cool slowly after welding.