

# Lastek 25

## Machinable surfacing

### CLASSIFICATION

EN ISO 14700 : E Fe1

### GENERAL DESCRIPTION

Good resistance to impact and wear.  
 Recommended for hard facing of wear parts that have to be machined afterwards.  
 Can be used as a base layer for extra hard wear facing layers.  
 Can be welded on A.C. despite the lime (basic) type coating.

### APPLICATIONS

Toothed wheels, rollers and sprocket wheels of bulldozers, roller bridges, winch drums, rails, cams, clutches, ...  
 Base layer for hard facings.

Hardness: 270 - 340 HB

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

<b>C :</b> 0.10	<b>Cr :</b> 3.50	<b>Mn :</b> 0.40	<b>Si :</b> 0.50	<b>Fe :</b> Balance
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### MECHANICAL PROPERTIES (Typical values, all weld metal)

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

### GENERAL INFORMATION

<b>Welding positions</b>	All			
<b>Shielding gas</b>	NA			
<b>Packing</b>	5 kg in a plastic box			
<b>Polarity</b>	AC or DC, reverse polarity (electrode positive)			
<b>Diameter (mm)</b>	2.5	3.2	4.0	5.0
<b>Length (mm)</b>	350	450	450	450
<b>Approx. current (A)</b>	65 - 85	100 - 130	120 - 180	170 - 240

**Tips & tricks** Weld with a short arc and low current to limit the dilution with the base material.  
 To obtain the maximum hardness, at least three layers are necessary.

*The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.*