

Lastek 256 A

Valves and valve seats

CLASSIFICATION

DIN 8555T1 : G 20-40
AWS A5.21 : ER CoCr-A

GENERAL DESCRIPTION

Cobalt based TIG- and oxy acetylene welding rod for hardfacing where maximum resistance to wear and corrosion at red heat temperature (up to 900-1.000 °C (1.650-1.830 °F)) is required.

Deposit machinable only with hard metal tools.

Excellent resistance to impact and thermal shocks and good resistance to acetic and nitric acid, organical chemical products such as: petroleum, plastic, rubber and resins, even liquid metals such as aluminium and zinc.

Also suitable for the food and pharmaceutical industry.

APPLICATIONS

Warm cutting tools, metal shear blades, stone breakers, hammers, valves and valve seats of combustion motors, glass cutting tools, shafts and pump bearings.

Hardness: 38-46 HRC.

Hot hardness: approx. 31 HRC @ 600 °C.

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

C : 0.90 - 1.40	Cr : 26.00 - 32.00	W : 3.00 - 6.00	Co : Balance	Si : < 2.00
Mn : < 1.00	Mo : < 1.00	Fe : < 3.00	Ni : < 3.00	

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 NA

Shielding gas Argon (or Argon/Helium mixed gas)

Packing 5 kg in a plastic box

Polarity DC, with the torch on the negative pole.

Diameter (mm) 2.4 3.2 4.0

Length (mm) 350 350 350

Tips & tricks

Remove all rust and dirt. Sharp edges should be rounded.

Heat the base metal until it 'sweats' (no melting).

Use a carburising flame, length of the feather approx. 2.5 to 3 times the length of the inner cone.

The surfacing can be lightly re-melted for optimum homogeneity.

Avoid too much dilution by using an as low as possible welding current.

For TIG welding, apply at least 2 layers in order to obtain the desired characteristics. (To avoid too much dilution with the base metal.)

On difficult to weld metals a base layer with Lastek 982 is recommended.

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.