

Lastek 27

Multilayer hardfacing

CLASSIFICATION

EN ISO 14700 : E Fe6

AWS A5.13 : E Fe5-B

GENERAL DESCRIPTION

The air hardening deposit of Lastek 27 is resistant to abrasion and impact.

Many layers can be built up without cracking.

Nevertheless, the wear resistance is much better than ordinary martensitic electrodes of the chromium - carbon type.

Also at elevated temperature applications (up to 550°C - 1020°F), Lastek 27 can be used.

APPLICATIONS

Soil abrasion (bucket edges, sand pump casings, bulldozer teeth).

Metal shears, stamping dies, mixer blades, ripper teeth, crusher jaws.

Hardness: 58 - 62 HRC.

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

C : 0.45 - 0.60	Cr : 9.50 - 10.50	V : 1.10 - 1.50	Mo : 0.50 - 1.50	Mn : 0.30 - 1.00
Si : < 0.90	P : < 0.025	S : < 0.025		

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, except vertical down.

Shielding gas NA

Packing 5 kg in a plastic box

Polarity AC or DC, reverse polarity (electrode positive)

Diameter (mm)	2.5	3.2	4.0	5.0
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Lenght (mm)	350	350	350	450
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Approx. current (A)	70	110	135	190
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Tips & tricks

- Electrode position: almost vertical to the work piece.
- Use a very short arc and keep the amperage as low as possible, to avoid too much dilution with the base material.
- To obtain the maximum hardness on mild steel, apply at least 3 layers.

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.