

Lastifil 236 TM

Seamless metal cored wire for hardfacing (600HB)

CLASSIFICATION

EN ISO 14700 : T Z Fe2

GENERAL DESCRIPTION

Copper plated, seamless metal cored wire for hardfacing. Very high resistance to wear caused by the abrasive action of minerals, clay, sand, gravel, ... Well suited for wear resisting parts subject to heavy impact and shock, the molten pool is easily controlled and the beads are smooth.

The absence of slag allows welding in several layers, without the necessity to remove the slag.

The deposited metal is crack-resistant, also after several layers.

The coppered wire is hermetically sealed and does not absorb moisture, not even after longer storage periods.

APPLICATIONS

Mechanical spades, bulldozers, scrapers, crushing hammers, bucket and loader teeth, conveyors, crusher jaws, crusher cones, etc.

Hardness: 55 - 65 HRC.

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

C : 0.50	Mn : 1.50	Si : 0.60	Cr : 6.00	Mo : 0.50
Fe : Balance				

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 Ar/CO₂, M21 (EN ISO 14175)

Packing 16 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 1.2 1.6

Tips & tricks

The coppered seamless wire can be welded with standard driving wheels but for smaller types of driving wheels the serrated wheels for tubular wire can work better.

Mixed gas Ar-CO₂ at about 12 litres a minute.

The interpass temperature should be maximum 250 °C.

The weld metal requires no buffer layer except on materials considered critical.

In this situation, Lastifil 20 TB or Lastifil 8070 is to be used as a buffer.

The weld metal is machinable by carbide tools, hardening is possible.

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.