PRODUCT SPECIFICATION

Lastek 27

Multilayer hard facing

CLASSIFICATION

EN ISO 14700 : E Fe8
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 Rc.

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/mm²	Tensile Strength N/mm²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

GENERAL INFORMATION

Welding positions	All			
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
Lenght (mm)	350	350	350	450
Approx. current (A)	70	110	135	190

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.