

Lastek 98

Ni based hardfacing electrode for hot work stamping dies

CLASSIFICATION

EN ISO 14700 : E Ni2

GENERAL DESCRIPTION

Excellent resistance to wear, corrosion and heat.

Maintains a good hardness even at very high temperatures.

Resistant to corrosion caused by acids and gases. (Good resistance to hydrochloric acid, sulphuric acid, phosphoric acid depending on concentration and temperature)

Crack free deposits with exceptional resistance to thermal and mechanical shocks.

Oxidation resistant up to 1200 °C (2200 °F).

APPLICATIONS

Forging dies, rollers and cutting tools exposed to high temperatures in rolling mills.

Accessories for thermal treatment; grates, baskets, ...

Surfacing of steam valve seats.

Protecting parts in seawater.

Hardness: 190 HB after welding // 42 HRC work hardened // 140 HB at 760 °C

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

C : < 0.08	Mn : < 0.70	Si : < 0.30	Cr : 15.00 - 17.00	Mo : 17.00 - 19.00
W : 5.00 - 6.00	Ni : 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)
	≥ 700 MPa	≥ 20%	

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

Length (mm) 300 300 350

Approx. current (A) 60 - 100 90 - 120 120 - 150

Tips & tricks Remove all cracks and fatigued metal by grinding.
The surface must be thoroughly cleaned from oil and grease.
Keep a very short arc.

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.