

# Lastifil 231

High hardness, excellent shock resistance

## CLASSIFICATION

DIN 8555 : MSG 4-60-S

## GENERAL DESCRIPTION

Solid welding wire with air hardening weld deposit.  
Highest hardness with excellent wear and shock resistance even at higher temperatures (up to 550 °C - 1.020 °F).  
Very good cutting properties.

## APPLICATIONS

Building or upgrading of low alloy steels to obtain high speed steel properties for hot and cold working applications.  
Repair of units that require long lasting sharp edges like tools, dies, shears, punches and knives.  
Hard facing of hammers.

Hardness: 62-66 HRC (as deposited - without preheat - cooled in air)

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

<b>C</b> : 1.00	<b>Cr</b> : 4.00	<b>Mo</b> : 8.30	<b>V</b> : 1.90	<b>W</b> : 1.80
<b>Mn</b> : < 0.50	<b>Si</b> : < 0.50	<b>P</b> : < 0.03	<b>S</b> : < 0.03	

## MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

## GENERAL INFORMATION

<b>Welding positions</b>	All
<b>Shielding gas</b>	Argon + 1 to 3% O2 or Argon + 1 to 3% CO2
<b>Packing</b>	15 kg spool (in a cardboard box)
<b>Polarity</b>	DC+
<b>Diameter (mm)</b>	1.2

**Tips & tricks** Remove all defects and foreign matter.  
Pre- and post-heat treatment may be necessary according to the type of base metal.

*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.*