

Lastifil 600

Hard, impact resistant hardfacing wire

CLASSIFICATION

EN ISO 14700 : S FE8
DIN 8555 : MSG 6-GZ-60-GP

GENERAL DESCRIPTION

Solid wire for hardfacings combining good resistance to abrasion and impact loading.
Multi layer welding is possible.
Due to the low welding current and the consequent low dilution, the hardness can be reached in one layer.

APPLICATIONS

Earthmoving equipment (bucket teeth and edges, track links), crusher hammers, dredging equipment, conveyor screws, ripper teeth, ...
Repair and fabrication of cutting tools.
Hardfacing of steel with material no 1.4718

Hardness: 57-60 HRC.
Tempering: 350-550°C (660-1020°F) in function of the desired hardness.

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

C : 0.40 - 0.50	Mn : 0.40 - 0.60	Si : 2.80 - 3.20	Cr : 9.00 - 9.50	S : < 0.025
Ni : < 0.03	P : < 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)
NPD	NPD	NPD	NPD

GENERAL INFORMATION

Welding positions	All		
Shielding gas	Ar/CO ₂ , M21 (EN ISO 14175) or 100% CO ₂		
Packing	15 kg spool (in a cardboard box)		
Polarity	DC+		
Diameter (mm)	1.0	1.2	1.6

Tips & tricks

- On problem steels, apply a buffer layer with Lastifil 807.
- Remove old or unknown surfacings before building up with Lastifil 600 (use Lastek 1900 to remove the old layers).
- The resulting hardness will be lower when the cooling rate of the deposit is low (e.g. on very thick surfacings, or on preheated workpieces).
- To obtain a maximum hardness level, let the workpiece cool down before applying a final layer with Lastifil 600.

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.