PRODUCT SPECIFICATION

Lastek 24

Severe abrasion

CLASSIFICATION

EN ISO 14700 : E Fe14 AWS A5.13 : E FeCr-A1

GENERAL DESCRIPTION

High chromium - iron alloyed electrode for applications subject to severe abrasion as by sand, cement, mud and others ... Good bond on steel, cast steel, manganese steel. Smooth deposit with very low friction coefficient. Long beads.

APPLICATIONS

Dredger teeth, grab jaws, stirring tools, mixers, wearplates, dredge pump parts, centrifugal pumps, augers, tillage tools.

Hardness: 57-62 HRC

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

C : 3.00 - 4.00	Cr: 27.00 - 32.00	P : < 0.025	S : < 0.025	Fe: Balance

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength	Tensile Strength	Elongation	Impact Strength
U	-	U	
N/mm²	N/mm ²	5d (%)	Charpy V notch (ISO-V)
			13 ()

GENERAL INFORMATION

Welding positions	PA, PB, PC				
Shielding gas	NA				
Packing	5 kg in a plastio	c box			
Polarity	AC or DC, reve	erse polarity (elect	rode positive)		
Diameter (mm)	2.5	3.2	4.0	5.0	
Lenght (mm)	350	350	350	450	
Approx. current (A)	60 - 90	120 - 140	140 - 170	150 - 200	

Tips & tricks

Electrode position: almost 90° to work piece.

Weld with a short arc and at lowest possible amperage to avoid dilution with the base material. To obtain a crack-free coating: pre-heat material according to the instructions of the supplier. For thick layers: Use Lastek 27 as base layer.

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.

