

Lastek 211

Very thin tungsten carbide deposits

CLASSIFICATION

DIN 8555 : E 21 GS 70 G

GENERAL DESCRIPTION

Electrode with a sintered carbide core and an extruded coating that guarantees a very thin and very large deposit with a superior abrasion resistance.

Machining is only possible with diamond tools.

One electrode of diameter 4 mm (5/32") covers an area of 100 cm² (16 square inches) and welds without interruption for about 6 minutes.

APPLICATIONS

Repairing tools in mining and cement industry, augers, mixer blades, furrowing shovel, rasp bars.

Hardness: 64 - 70 HRC.

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

WC : 66.00	Si : 1.50	Fe : 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)

GENERAL INFORMATION

Welding positions PA, PB, PC

Shielding gas NA

Packing 5 kg in a plastic box

Polarity AC or DC, reverse polarity (electrode positive)

Diameter (mm) 3.2 4.0

Length (mm) 350 350

Approx. current (A) 100 120

Tips & tricks Keep an arc length of about 3 to 5 mm (0.12 to 0.20 inch), with the electrode almost perpendicular to the work piece.
For maximum wear resistance apply a base layer of Lastek 27.
If grinding is necessary, use a diamond tool.

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.