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 N/mm²	Tensile Strength N/mm²	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)	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.