PRODUCT SPECIFICATION

Lastek 262 E



Rubber, paper and plastics

CLASSIFICATION

EN ISO 14700 : E Co3 AWS A5.13 : ~E CoCr-B

GENERAL DESCRIPTION

Cobalt base electrode for friction and corrosion resistant hardfacings.

Excellent resistance to high temperatures (up to 1000 °C) (1830 °F).

Machinable with hard metal tools.

Good shock resistance.

Resistance to nitric and acetic acid, superheated steam, flue gases, petroleum and plastics.

APPLICATIONS

Machine-parts for the manufacturing process of paper and plastics and wood. Axles and bearings of centrifugal pumps, dies.

Hardness: 47 - 53 HRC.

Hot hardness: approx. 34 HRC @ 600 °C (1110 °F).

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

C:	1.50 - 1.90	Cr: 27.00 - 32.00	Fe: < 3.00	Mn: < 1.00	Mo: < 1.00
Ni:	< 3.00	Si : < 2.00	W : 7.50 - 10.00	Co: Balance	

MECHANICAL PROPERTIES (Typical values, all weld metal)

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

GENERAL INFORMATION

Welding positions	PA, PB, PC				
Shielding gas	NA NA				
Packing	5 kg in a plastic box				
Polarity	AC or DC, reverse polarity (electrode positive)				
Diameter (mm)	3.2	4.0			
Lenght (mm)	350	350			
Approx. current (A)	80 - 95	100 - 130			

Tips & tricks Remove all rust and dirt.

Sharp edges must be rounded for optimum adhesion.

The arc should be short to avoid too much dilution with the base metal.

On crack sensitive steels, apply a base layer with Lastek 9066.

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.

www.lastek.be PSEN_L262E_N0524_TW