

# 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)

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

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

### GENERAL INFORMATION

<b>Welding positions</b>	PA, PB, PC	
<b>Shielding gas</b>	NA	
<b>Packing</b>	5 kg in a plastic box	
<b>Polarity</b>	AC or DC, reverse polarity (electrode positive)	
<b>Diameter (mm)</b>	3.2	4.0
<b>Length (mm)</b>	350	350
<b>Approx. current (A)</b>	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.