

# Lastofil 2017 G

## High abrasion and impact resistance

### CLASSIFICATION

EN ISO 14700 : T Fe 8-60-GP

DIN 8555 : MF 10-GF-60-GP

### GENERAL DESCRIPTION

Cored wire for hardfacing parts that have to resist high impact loads in combination with severe abrasion. The combination of the tough matrix and the very hard special carbides gives an abrasion resistant deposit that is not susceptible to high impact loads.

### APPLICATIONS

Crusher cylinders, crusher hammers, bucket teeth and lips, sandpumps, impellers and screws, cane shredders and knives, bed knives and anvils in pulp and paper industry.

Hardness: 56 - 59 HRC

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

<b>C :</b> 1.50 - 1.80	<b>Si :</b> 1.00 - 1.80	<b>Mn :</b> 0.70 - 1.40	<b>Cr :</b> 6.50 - 8.00	<b>Mo :</b> 1.10 - 1.50
<b>Ti :</b> 4.50 - 5.50	<b>Fe :</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

**Welding positions** All, except vertical down.

**Shielding gas** Without shielding gas

**Packing** 15 kg spool (in a cardboard box)

**Polarity** DC+

**Diameter (mm)** 1.2 1.6

**Approx. current (A)** 150 - 200 180 - 240

**Tips & tricks** Open arc welding  
Stick-out: 30 - 40 mm (1,18 - 1,57")  
Wire feed: 5m/min (197"per min)  
Remove all worn out material. Preheat high carbon and low alloyed steels.  
When welding manganese steels, temperature should remain below 300 °C (570 °F).

*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.*