PRODUCT SPECIFICATION

Lastifil 239 GM

Metal powder cored wire - 600 Brinell - Open Arc

CLASSIFICATION

EN ISO 14700 : T Z Fe8

GENERAL DESCRIPTION

Cored wire for hardfacing parts that have to resist severe abrasion in combination with high impact loads.
The combination of the tough matrix and the very hard Niobium carbides gives an abrasion resistant deposit that can withstand shocks.
The absence of slag allows welding in several layers without the elimination of slag.
Three layers can be built up without cracking.

APPLICATIONS

Crusher cylinders, crusher hammers, bucket teeth and lips, sandpumps, impellers and screws.
Cane shredders and knives.
Knives and mixers in the pulp and paper industry.

Hardness: 56 - 64 HRC (is obtained from the first layer).

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

C : 1.30	**Mn :** 0.80	**Si :** 1.40	**Cr :** 6.50	**Nb :** 6.50
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, PF			
Shielding gas	M21, C1 or without shielding gas			
Packing	16 kg spool (in a cardboard box)			
Polarity	DC+			
Diameter (mm)	1.2	1.6	2.4	2.8

Tips & tricks

Open arc welding (no shielding gas required).
Stick-out: 30 - 40 mm (1.2"-1.6").
Remove all worn out material.
Preheat high carbon and low alloyed steels.
On steels with bad weldability, it is advisable to apply a base layer with Lastifil 8071 in order to avoid cracking.