

Lastifil 2400 G

Flux cored wire with outstanding abrasion resistance

CLASSIFICATION

EN ISO 14700 : T Z Fe15

Din 8555 : MF 10-65-G

GENERAL DESCRIPTION

Lastifil 2400G is a flux cored wire that can be used without shielding gas. It is recommended for applications involving severe abrasion, or for abrasion coupled with impact.

The weld metal is not machinable.

Good hardness up to 550 °C (1020 °F).

APPLICATIONS

Mineral wear applications as excavator teeth, bulldozer blades, bucket lips, coal screw conveyors, chip chute liners, spreader cones (brick industry), rotary hoe teeth, pulping knives, extrusion of rubber.

Crushers for stone and rock (cement industry - stone quarries).

Bone crushers.

Hardness: 63 – 67 HRC.

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

C : 5.20	Si : 1.30	Mn : 0.40	Cr : 22.00	Nb : 7.00
B : 1.00				

MECHANICAL PROPERTIES (Typical values, all weld metal)

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

GENERAL INFORMATION

Welding positions All, except vertical down.

Shielding gas Without shielding gas (or M13)

Packing 15 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 1.2 1.6 2.4

Tips & tricks

Use a stick-out (distance from contact tip to the extremity of the wire) of 20 to 50 mm (1-2") for open arc welding.

Lastifil 2400G can be used without shielding gas. However the best fluidity and almost spatter free welding is obtained by using an extra gas Ar + 2% O₂ (shielding gas M13 according to EN ISO 14175) in the spray arc zone.

For a correct wire feed, use appropriate drive rolls for cored wire in the wire feeder and a water cooled torch that is smoothly inclined.

On crack sensitive steels or for hardfacings where heavy impact occurs, use a base layer of Lastifil 8071.

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.