

Lastifil 261 G

Stellite 21 welding wire

CLASSIFICATION

DIN 8555 : MF 20-300/450-CKPTZ

AWS A5.21 : ER CCoCr-E

GENERAL DESCRIPTION

Corrosion resistant CoCrMo flux cored wire containing dispersed hard carbides which strengthen the alloy and increase its hardness but also decrease the ductility.

Lastifil 261G has excellent cavitation, galling and metal-to-metal sliding wear resistance. It is however not recommended for severe hard particle abrasion.

Lastifil 261G is resistant to oxidizing and reducing gaseous atmospheres up to 1150°C.

APPLICATIONS

Chemical and petrochemical valves.

Jet engines.

Valves in the petrochemical industry which are submitted to high temperatures in an environment where cavitation, erosion and corrosion is rife.

Medical applications.

Hardness after welding: 27 HRC.

When cooled down, the hardness increases up to 48 HRC.

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

C : 0.15 - 0.40	Cr : 25.00 - 30.00	Mo : 4.00 - 7.00	Ni : 1.50 - 4.00	Mn : < 2.00
Si : < 1.50	Fe : < 5.00	W : < 0.50	Co : Balance	

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 Argon

Packing 15 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 1.2

Tips & tricks

Clean the surface by grinding and remove dirt, oil, paint, rust and other impurities.

If applied on crack sensitive steels, use a base layer of Lastifil 807 or Lastifil 85.

Preheat according to the information given by the supplier of the base material.

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.