

Lastifil 251 G

Cored wire on cobalt base - very hard

CLASSIFICATION

EN ISO 14700 : T Co 3-55-CGTZ

AWS A5.21 : ER CCoCr-C

GENERAL DESCRIPTION

Lastifil 251G deposits an alloy on cobalt base that is resistant against abrasion, corrosion and high temperatures (up to 1000 °C (1830 °F)).

The hardness obtained is independent of the cooling rate and is not changed by any heat treatment.

APPLICATIONS

Rebuilding cutting blades, valve seats, guides in hot-rolling mills, extrusion blades, tar scrapers.

Hardness: 51 - 56 HRC.

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

C : 2.20 - 2.60	Cr : 26.00 - 29.00	W : 9.50 - 12.00	Mn : 1.30 - 1.50	Si : 0.40 - 0.80
Fe : < 5.00	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 PA, PB, PC

Shielding gas Ar/CO₂ (M12: EN ISO 14175)

Packing 15 kg spool (in a cardboard box)

Polarity DC+

Diameter (mm) 1.0 1.2 1.6

Tips & tricks

Remove dirt, oil and all fatigued metal by grinding.

Preheat thick pieces that are prone to cracking to about 250 °C (480 °F).

Cool down slowly.

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.