

**Abrasion and impact****CLASSIFICATION**EN 14700 (E Fe16)  
DIN 8555 (E 10 UM 65Z)**GENERAL DESCRIPTION**

Hard facing electrode with first layer hardness up to 68 Rc on mild steel, depending on the parent metal. The wear facing shows little or no transverse cracking.

Good shock-resistance.

Smooth arc.

Easy to strike.

High hardness at elevated temperatures (up to 600 °C(1100 °F)) - (38-40Rc)

**TYPICAL USE**

Recommended for severe wear accompanied by moderate to high impact.

Bone crushers, dredging teeth, feed screws in cement factories (fueller pumps) cement mixers, pulping knives etc.

Hardness: 60-68 Rc

Efficiency 195 %

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

C	Cr	V	Mn	Si	P & S	Fe
< 5.00	20.00 - 25.00	9.00 - 12.00	0.50 - 2.00	< 2.00	< 0.030	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:** PA, PB, PC

**Shielding gas:** NA

**Dia (x length) (mm):** 2.5 - 3.2 (x 350) / 4.0 (x 450)

**Packing:** 5 kg in plastic box

**Polarity:** AC or DC, reverse polarity (electrode positive)

**Tips & tricks:** Remove fatigued or cracked metal with Lastek 1900 or Lastek 1000.  
For surfacing more than two layers use Lastek 27 as a base layer and Lastek 2400 to finish.  
The electrode must be kept vertical to the work piece in order to obtain the maximum hardness.  
Keep amperage as low as possible to avoid dilution with the base metal.

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.