

Flux cored hardfacing wire - Heavy impact resistance - Joining problem steels**CLASSIFICATION**

EN 14700 (T Fe 9)
Din 8555 (MF 7-250-KNP)

GENERAL DESCRIPTION

Self shielded flux cored wire for building up multi-layer deposits on badly worn components.
To be used as buffer layer on crack sensitive steels.
Under repeated impact the austenitic deposits become tougher and harden very quickly.
Lastifil 8071 can also be used for joining 12% Manganese steel and high carbon steels.
The ductile deposit prevents crack formation on those carbon steels and on problem steels.
The deposit is rust proof.
Hardness as deposited : 220 - 250 HB (work hardened up to 500 HB)

TYPICAL USE

Crusher jaws, swing hammers, rail crossings, gyratory cones, dredge bucket lips.
Joining of 12%Mn steel.
Buffer layers for Lastifil 2400G.

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

C	Si	Mn	Cr	Ni	Mo	V
0.30 - 0.50	0.30 - 0.60	15.0 - 17.0	13.5 - 15.0	1.0 - 2.0	0.5 - 0.7	0.15 - 0.25

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)
	> 850 MPa	≥ 35%	

General information

Welding positions: All, except vertical down.

Shielding gas:

Dia (x length) (mm): 1.2 - 2.8

Packing: 15 kg spool (in cardboard box)

Polarity: NA

Tips & tricks: Lastifil 8071 can be used without separate shielding gas.
Shielding gas M13 (Argon / 1-2 % O₂) can be used if required.
Use a stick-out (distance from contact tip to the extremity of the wire) of 20 to 50 mm.
For a correct wire feed, use appropriate drive rolls in the wire feeder.

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.