



LZ1579

CLASSIFICATION:

EN14700 DIN 8555
T Fe 15 MF 10-60-G

CHARACTERISTICS

LZ1579 is C-Cr-Mo alloyed open arc hardfacing flux cored wire, properties as follow:

- Shielding: Open arc
- Hardfacing deposit metal property: excellent impact resistance
- Weldability: Little spatter, excellent anti-porosity, tiny checking
- Acceptable parent material: any steel
- Hardfacing thickness limit: Not exceed to 8mm
- Checking resistance: Depends on parent material, workpiece size, hardfacing thickness, welding process, etc.
- Machining: milling & grinding
- Dia.&Package: φ 1.2mm/1.6mm 15kg/spool

APPLICATION

Flange hardfacing.

TYPICAL ALL WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe
2.5	1.75	2.0	10.7	1.5	Bal.

Hardness: 44-47HRC

Welding Position: Flat

PARAMETER

Diameter	Voltage	Amps	Stickout	Preheating	Interpass
1.6mm	25-29V	200-300A	20-25mm	200-300℃	200-300℃
1.2mm	27-31V	250-350A	15-25mm		

◇ φ 1.6mm deposit rate: 90%

◇ φ 1.6mm hardfacing efficiency: 5kg/h

Remark: Chemical composition and hardness are tested according to prescribed standard, actual results might be vary depending on many factors, like weld procedure, temperature etc, please contact our sales before use it in the intended application

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