

 Welding technology	technical-metallurgical data sheet for LAWITEX - filler metals	LAWI 24
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This basis classifies is also a guideline for quality protection.

Form: **filler metal**

LAWITEX-description **LAWI 24**

Cr-Mo-V-W filler metal with stabilizing elements. The welding deposit is air hardenable and shock hardenable. Edge stable and resistant at elevated temperatures. Qualificatorily chromium-plateable, it is polishable, erodable, nitrable, etchable and temperable good heat conducting properties. For Aluminium diecasting forging dies, slide tolls. Hardness 1-st layer approx. 56-59 HRC. Hardenable up to approx. 58 HRC for multi-layer welding.

Analyse % - steels

C	Al	Co	Cr	Cu	Fe	Mn	Mo	Ni	Si	V	W	Su%
0,35	0,03		5,3		Rest	0,60	1,50		0,70	0,80	0,40	

The technical results are dependent on the extent of mingling to the basic materials and also a indication of the process engineering.

Department of Quality