

# LH 106 SMP

ELECTRODE FOR LOW & MEDIUM CARBON STEELS AS WELL AS MEDIUM TENSILE STEELS OF VARIOUS COMPOSITIONS

## PROPERTIES

- The weld metal has Nuclei treated element which produces Controlled Grain Structure as well as Controlled Ferrite Content.
- This combination gives higher strength as well as ductility which is required when welding difficult to weld steels.
- Electrode has Spray type metal transfer ensures welding in Lowest Current and also very controlled penetration with Minimum base metal dilution.
- Can be used on low amperage, has easy striking and re-striking characteristics.
- The weld metal is crack, heat resistant and is extremely tough.
- The weld metal is resistant to shocks due to impact.
- The deposit is machinable & shock proof.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	1.6x250	25-35
	2.5x350	50-75
	3.2x350	70-110
	4.0x350	90-140
	5.0x350	140-180

## TYPICAL APPLICATIONS

For joining dissimilar steels of unknown composition with different thickness, welding of dies, springs, shaft splines, gears, punches, etc.

For depositing cushioning layer on difficult to weld steels before depositing final surfacing layer.

## PROCEDURE

Clean the affected area from oil, grease, etc. Bevel 90° U groove using LH 900. Hold short arc & deposit stringer beads. Preheat as necessary. Chip the slag between passes. Maintain inter-pass temp. below 200°C. Allow the job to cool slowly.



## SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn



## TECHNICAL DATA

UTS : 70-90 kgf/mm<sup>2</sup>  
Elongation : 22-25%