

# LH 124

AUSTENITIC STAINLESS STEEL ELECTRODE  
FOR WELDING AISI 304, 304L

## PROPERTIES

Corrosion and scale resistant deposit with extremely low carbon content ( $C < 0.04\%$ ). Easy arc striking. Flat shining bead, free from inter-granular corrosion.

## PROCEDURE

De-grease and clean the area to be welded. For heavy thickness prepare a  $60^\circ$  included angle V. Fit up should be accurate for long joints. Weld at regular intervals and use jigs and fixtures to avoid distortion. Use DCRP (DC+) on DC Power Source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-70
	3.2x350	80-100
	4.0x350	100-140

## TYPICAL APPLICATIONS

For hardfacing of parts subject to heavy abrasion and metal-to-metal wear with mild impact and temperature upto  $650^\circ\text{C}$ . Suitable for: refractory press screws, brick press screws, cement press screws, palm oil expeller flights, conveyor screws, impellers, dredging cutter & drag head, runner bottom edge, pug mill, knife, wing knife, auger, boring bits, blast furnace bells and hoppers.



## SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni



## TECHNICAL DATA

UTS :53-65 kgf/mm<sup>2</sup>  
Elongation:35-40%