

LH 125



AUSTENITIC STAINLESS STEEL
ACID-RESISTANT ELECTRODE FOR
WELDING AISI 316, 316L

PROPERTIES

The extra low carbon weld deposit, is highly corrosion resistant against strong chemical influence. Resistant against grain disintegration upto 300°C.

PROCEDURE

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

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	80-100
	4.0x350	100-140

TYPICAL APPLICATIONS

Welding of Austenitic stainless steels, Cr-Ni- Mo steels of the type 18 Cr / 8 Ni+Mo (V4A, AISI 316, Ugine NSM 22, Avesta 832 SK, Soderfors 564, Sandvik OR 60, UHB stainless 2 4 , e t c .) . Dyeing and dairy equipment, Chemical vessels, Brewery and food equipment.



SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni, Mo



TECHNICAL DATA

UTS : 54-70 kgf/mm²
Elongation : 30-40%