

# LH 126



FULLY AUSTENITIC HEAT RESISTANT  
STAINLESS STEEL ELECTRODE FOR  
WELDING 25/20 STAINLESS STEELS

## PROPERTIES

Fully Austenitic weld deposit, heat resistant upto 1200°C in oxidizing and sulphur free atmosphere.

## 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 | 50-75   |
|             | 3.2x350 | 90-110  |
|             | 4.0x350 | 120-140 |

## TYPICAL APPLICATIONS

For hardfacing of parts subject to heavy abrasion and metal-to-metal wear with mild impact and temperature upto 650° 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:55-65 kgf/mm<sup>2</sup>  
Elongation:30-35%