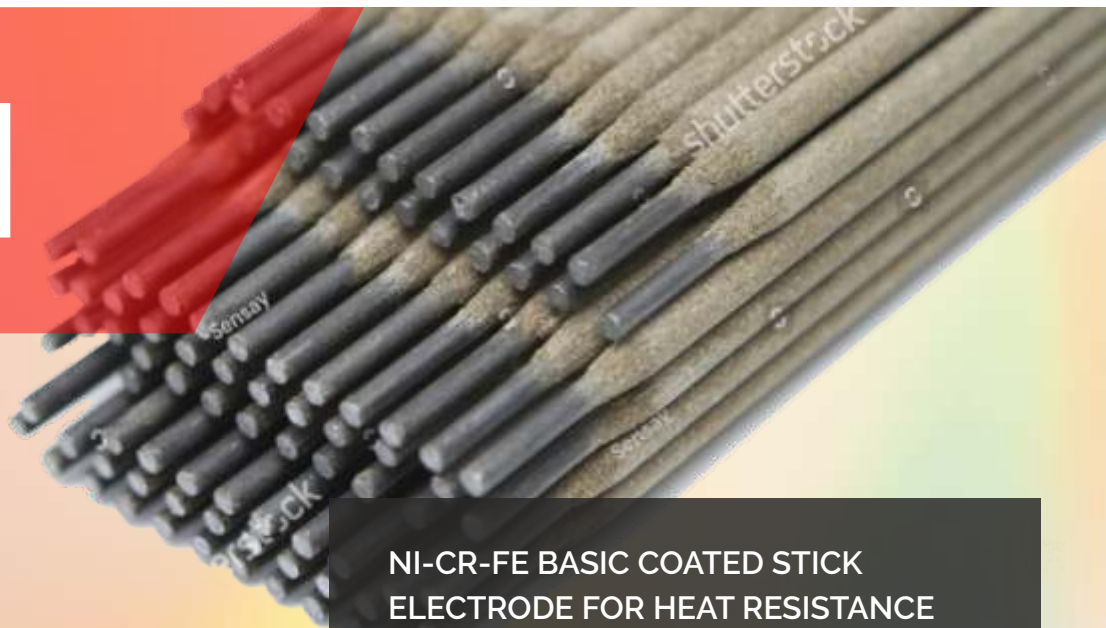


# LH 521



NI-CR-FE BASIC COATED STICK  
ELECTRODE FOR HEAT RESISTANCE

## PROPERTIES

The electrode gives soft stable arc on low currents. Deposits are smooth, tough and has excellent resistance to scaling, corrosion resistance at normal as well as elevated temperatures. Also possesses good thermal cycles and shock resistance. Any amount of buildup is possible. The deposit is tough and free from porosity.

## PROCEDURE

Clean the workpiece thoroughly for a crack and porosity free deposit. Adopt short arc and ensure minimum heat input using lowest possible amperage. Adopt stringer bead technique. Dry electrode for 1 hour at 300°C. Preheat the base metal to avoid martensite formation in the HAZ. Fill the craters by dwelling or back whipping.



## SPECIFICATIONS

ALLOY BASIS: Ni, Cr, Mn, Fe, Nb  
AWS 5.11 E: Ni Cr Fe-3



## TECHNICAL DATA

UTS : 55-60 kgf/mm<sup>2</sup>  
Elongation : 30-35%

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-80
	3.2x350	90-110
	4.0x350	110-140
	5.0x350	140-160

## TYPICAL APPLICATIONS

This is a versatile electrode for welding of nickel, inconel, monel, nickel-chromium-iron alloys. Weld deposits are similar to ENiCrFe3. HK alloys, steel, stainless steel and heat resisting steels. Also for welding dissimilar metals such as carbon steels, stainless steels, nickel, nickel alloys to each other. For use on equipment and components made of pure nickel, for fabrication of corrosion resistant tanks and containers, heat exchangers, furnace components, boilers, fittings, anchors, mill trunnions, symmetry gears, etc.