

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/mm²
Elongation:30-35%