

LH 105 LMP



ELECTRODE FOR LOW AND MEDIUM CARBON STEELS AS WELL AS MEDIUM TENSILE STEELS OF VARIOUS COMPOSITIONS

PROPERTIES

Moisture resistant basic coated hydrogen-controlled electrode. The deposited weld metal is very tough and has high impact value. The weld metal is ductile and resistant to cracking. Can be used in all positions.

PROCEDURE

Clean the area to be welded. Adopt short-medium arc to avoid overheating. Use DC power source for best results. Preheat base metal if necessary.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-85
	3.2x350	100-140
	4.0x350	140-180
	5.0x350	160-210

TYPICAL APPLICATIONS

For welding of low and medium carbon steels and medium tensile steels of various composition. For welding pressure vessels, pipe welding, fabrication and repair welding of heavy machinery parts, steel castings, sluice gates, etc. For heavy restrained joints where minimum distortion is desired. An excellent electrode for repair at site, for repairs at dams, power stations, etc.



SPECIFICATIONS

ALLOY BASIS: C, Mn, Si



TECHNICAL DATA

UTS : 50-54 kgf/mm²
Elongation (L=4d) : 22-30%