

LH 106 SMP



AUSTENO-FERRITIC ELECTRODE WITH EXCELLENT DUCTILITY AND HIGH TENSILE STRENGTH

PROPERTIES

The weld metal has Nuclei treated element which produces Controlled Grain Structure as well as Controlled Ferrite Content. This combination gives higher strength as well as ductility which is required when welding difficult to weld steels. Electrode has "spray type" transfer and weld beads are smooth with uniform ripples. Can be used on low amperage, has easy striking and re-striking characteristics. The weld metal is crack, heat resistant and is extremely tough. The weld metal is resistant to shocks due to impact. The deposit is machinable and shock proof.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	80-110
	4.0x350	110-150
	5.0x350	140-180

TYPICAL APPLICATIONS

For joining dissimilar steels of unknown composition with different thickness, welding of dies, springs, shaft splines, gears, punches, etc. For depositing cushioning layer on difficult to weld steels before depositing final surfacing layer.

PROCEDURE

Clean the affected area from oil, grease, etc. Bevel 90° U groove using LH 900. Hold short arc and deposit stringer beads. Preheat as necessary. Chip the slag between passes. Maintain inter-pass temperature below 200°C. Allow the job to cool slowly.



SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn



TECHNICAL DATA

UTS : 70-90 kgf/mm²
Elongation : 22-25%