

LH 1061



AUSTENO-FERRITIC, HIGHLY
CRACK-RESISTANT ELECTRODE
HAVING HIGH TENSILE STRENGTH

PROPERTIES

Weld metal having exceptional crack-resistant properties. Easy arc control, almost nil spatter loss and extremely easy slag removal. No slag interference. Easy re-striking, good wetting characteristics and smooth arc.

PROCEDURE

Clean the area to be welded. Preheat medium carbon and alloy steels. Hold short arc and deposit stringer beads. Maintain inter-pass temperature below 200°C. Chip the slag between passes, post-heat the job to 450°C and cool slowly to room temperature.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	80-100
	4.0x350	100-140

TYPICAL APPLICATIONS

Used for joining or surfacing of any carbon steel of unknown composition. Suitable for welding all types of low and high-alloy steel, tool steel, spring steel, manganese steel, high-speed steel, case-hardened steel. Recommended for joining dissimilar steels.



SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn



TECHNICAL DATA

UTS : 75-85 kgf/mm²
Elongation (L=4d) : 22-26%