

LH 107

ELECTRODE FOR HIGH RESISTANCE
TO HEAT AND CORROSION

PROPERTIES

Fully austenitic electrode with high strength, resistance to heat & corrosion. Scale resistance up to 1200°C. The deposit is tough, crack-proof and wear resistant. Suitable for positional welding.

PROCEDURE

Clean the area to be welded thoroughly. Prepare edges of heavy section depending on thickness. Preheating depends on the composition of parent metal. Stringer bead technique with short arc is recommended. De-slag every pass for good penetration. Bake the electrode at 300°C for 1 hour. Back whip to fill craters.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	90-110
	4.0x350	120-140

TYPICAL APPLICATIONS

Used for joining and surfacing of all types of steels, alloy steels, heat, scale resistant steels, manganese steels and dissimilar steels. As a cushioning layer under hard deposits, fabricating and repairing of valves, rolls, gears, hot dies, gas turbines, parts subject to heat, corrosion and impact. Cladding Carbon steels, hydrogenation plants, combustion chamber parts, furnace parts, etc.



SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn



TECHNICAL DATA

UTS : 55-65 kgf/mm²
Elongation : 30-35%