

LH 108

ELECTRODE FOR WELDING AUSTENITIC
MANGANESE STEELS

PROPERTIES

Specially formulated low-heat input austenitic stainless-steel electrode. Has excellent heat resistance upto 900°C, impact, resistant to corrosion by atmosphere, sea water, weak acids, etc.

PROCEDURE

Adopt short arc and adjust low amperage, especially for high Manganese Steel. Peen and de-slag each pass. Use water bath to contain heat buildup.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	90-110
	4.0x350	120-150
	5.0x350	150-180

TYPICAL APPLICATIONS

Used for joining Austenitic Manganese Steels (14% Mn). Ideal for joining Austenitic Manganese Steels to Mild Steels, Difficult Steels, High Alloy Steels, etc. Ideal for providing 'Elastic Interlayer' - (cushioning layer) before hard surfacing. Surfacing manganese steel rails. Repairing cracks in austenitic manganese steel castings, joining buckets cracks on earth moving equipment in mining industry.



SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn



TECHNICAL DATA

UTS : 58-65 kgf/mm²
Elongation (L=4d) : 30-40%