

LH 124

AUSTENITIC STAINLESS STEEL
ELECTRODE FOR WELDING AISI 304, 304L

PROPERTIES

Corrosion and scale resistant deposit with extremely low carbon content ($C < 0.04\%$). Easy arc striking. Flat shining bead, free from intergranular corrosion.

PROCEDURE

De-grease and clean the area to be welded. For heavy thickness prepare a 60° included angle V. Fit up should be accurate for long joints. Weld at regular intervals and use jigs and fixtures to avoid distortion. Use DCRP (DC+) on DC Power Source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-70
	3.2x350	80-100
	4.0x350	100-140

TYPICAL APPLICATIONS

For joining 18/8 stainless steels, e.g. V2A, AISI 304 / 308, En 58A, B, C; Ugine NS 22, Avesta 832 NV, Soderfors 553, Sandvik Or2, UHB Stainless 3, Stay bright FSL., Silver Fox 304, etc., which are used in chemical plants, dye works, breweries, food industry and hospital equipment.



SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni



TECHNICAL DATA

UTS : 53-65 kgf/mm²
Elongation : 35-40%