

LH 126 HC



FOR WELDING Hk30, HK40 AND SIMILAR
HEAT-RESISTING ALLOYS

PROPERTIES

Easy arc striking, slag removal, evenly rippled shining bead. The weld deposit can withstand temperatures up to 1200°C in continuous service. Creep rupture strength at working temperature is quite high. This high carbon electrode is intended for service at elevated temperatures where creep resistance is of primary importance.

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 & fixtures to avoid distortion. Use DCRP (DC+) on DC Power Source for good ripple & finish. Stringer bead technique with shortest possible arc length is recommended.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	3.2x350	90-110
	4.0x350	130-160

TYPICAL APPLICATIONS

For welding reformer tubes (also called furnace tubes) made of HK 30 and HK 40 alloys used in fertilizer industry, oil refineries, petrochemical plants, cement industry, steel industry, etc.



SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni, C



TECHNICAL DATA

UTS : 60-70 kgf/mm²
Elongation : 10% min.