

LH 126



FULLY AUSTENITIC HEAT RESISTANT
STAINLESS STEEL ELECTRODE FOR
WELDING 25/20 STAINLESS STEELS

PROPERTIES

Fully Austenitic weld deposit, heat resistant upto 1200°C in oxidizing and sulphur free atmosphere.

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 (+)	2.5x350	50-75
	3.2x350	90-110
	4.0x350	120-140

TYPICAL APPLICATIONS

Welding of Austenitic stainless steels, heat resistant Cr-Ni steels of the type 25 Cr / 20 Ni (NCT, AISI 310, Ugine NS 30, Avesta 254 E, Sandvik 15 RE 10). Also suitable for welding of steels with high carbon content often used in the cement industry for anchor welding. Furnace linings, furnace parts, burners, heat treatment pots and baskets.



SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni



TECHNICAL DATA

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