

LH 127

ELECTRODE FOR WELDING AND SURFACING 13% CHROMIUM STEELS, HYDRO-TURBINES

PROPERTIES

Weld metal is of radiographic quality, resistant to corrosion, oxidation, friction and cavitation.

PROCEDURE

Clean the area affected. Pre-heat base material to 200°C. Deposit at low currents holding short arc. Post heating martensitic stainless steel to 600°C and slow cool to room temperature.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-80
	3.2x350	80-110
	4.0x350	120-150

TYPICAL APPLICATIONS

Welding and surfacing 13% chromium steels, armature, turbines, Impellers, runners valves, pumps, etc.



SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni



TECHNICAL DATA

UTS : 47-57 kgf/mm²
Elongation : 18-25%