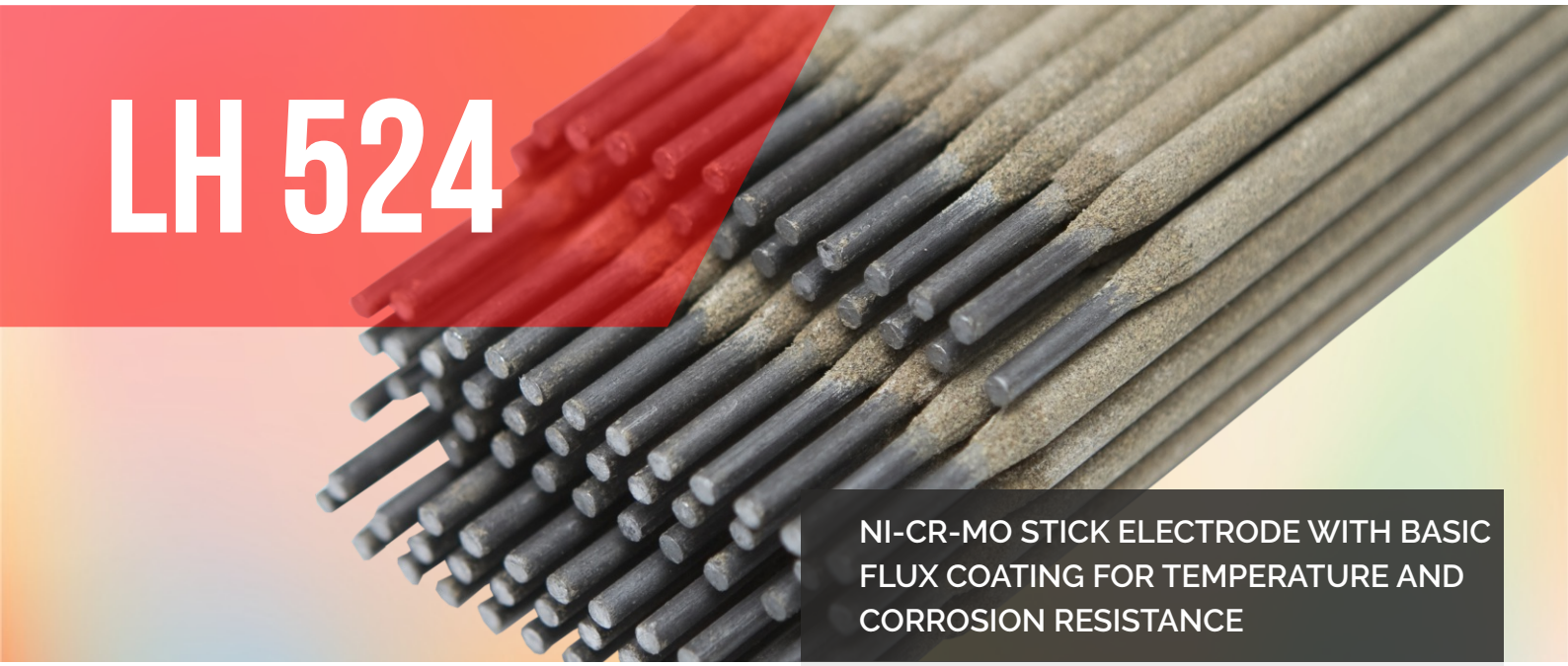
LH-ALLOY®

LH 524



NI-CR-MO STICK ELECTRODE WITH BASIC FLUX COATING FOR TEMPERATURE AND CORROSION RESISTANCE

PROPERTIES

The weld deposit is resistant to seawater corrosion, wide variety of acids and alkalis. High resistance to pitting, crevice, inter-crystalline and stress corrosion cracking. High temperature strength and oxidation stability.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-80
	3.2x350	80-110
	4.0x350	110-140

PROCEDURE

Clean the work piece thoroughly for a crack and porosity free deposit. Adopt short arc and ensure minimum heat input using lowest possible amperage, follow stringer bead technique. Dry electrode for 1 hour at 300ºC to remove moisture. The crater to be filled properly by back whipping or dwelling. The crater to be filled properly by back whipping or dwelling.

TYPICAL APPLICATIONS

To join and hard-surfacing of identical or similar grades of heat-resisting steels and alloys. Also for welding alloy steels like H 11, H 13, 17 Mn 4, St E 355, 15 Mo 3, 15 Mn Ni 6 3, 13 Cr Mo 4 4, 10 Cr Mo 9 10 u. X 8 Ni 9. Specially suitable in sea water and offshore plants, chemical-engineering (nitric, sulphuric, hydrochloric, phosphorous acid as well as alkalis), flue gas dust collectors.

SPECIFICATIONS

Alloy Basis Cr, Ni, M0, Mn, Nb, Fe
AWS / A 5.11 Ni Cr Mo-3

TECHNICAL DATA

UTS 76-80 kgf/mm^2
Elongation 30-35%

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