

LH 717



**CORROSION AND OXIDATION RESISTANT
FOR SURFACING & JOINING**

PROPERTIES

Heavy coated electrode with excellent welding characteristics. The deposit is resistant to corrosion and oxidation which is also free from cracks and porosity. The deposit resists deformation from static or cyclic loads at high temperatures.

PROCEDURE

Clean the affected area. Weld with lowest possible heat input. Maintain inter-pass temperature below 100°C. The electrode has a special formulation which minimizes the precipitation of inter-metallic phase.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5 x350	70-110
	3.2x350	90-120
	4.0x350	110-140
	5.0x350	160-210

TYPICAL APPLICATIONS

Fabrication and repair of hot pressing tools as well as surfacing of parts subject to abrasion, oxidation and corrosion. Drop-forge dies, hot trimming tools, pump impellers, valves. Ideal for crack-free welding of parts subject to thermal and chemical influence, i.e., for joining of heating elements.



SPECIFICATIONS

ALLOY BASIS: Ni, Cr, Mo, W

TECHNICAL DATA

UTS:70-75 kgf/mm²

Elongation:25-30%

Hardness as welded: 20-24 RC

Work hardened:42-48 RC

Metal recovery:150%

