

# LH 103

A CONTACT ELECTRODE FOR SPEEDY,  
ALL-POSITION WELDING OF MILD STEEL

## PROPERTIES

Weld bead is smooth, uniform and of radiographic quality. Slag removal is very easy and self peeling in most cases. Since contact welding is possible, no skill is required while welding and welder's fatigue is reduced. It is possible to use currents still lower than those specified for welding thin sheets to avoid distortion and warpage.

## PROCEDURE

Clean the joint area thoroughly. Use recommended current, with reverse polarity on DC power source for deep penetration. Adopt skip welding technique on thin sheets on vertical down positions. Hold short to medium arc with slight weaving.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-80
	3.2x350	75-100
	4.0x350	100-135
	5.0x350	125-150

## TYPICAL APPLICATIONS

Auto-bodies, chassis, steel doors and windows, steel furniture, storage tanks, pipes, sheet metal works, etc. Best suited for bridging wide root-gaps.



## SPECIFICATIONS

ALLOY BASIS: Mn, Si, C



## TECHNICAL DATA

UTS : 45-51 kgf/mm<sup>2</sup>  
Elongation : 17-20%