

LH 104



LOW HYDROGEN ELECTRODE FOR
MEDIUM TENSILE, DUCTILE STEEL
WELDS

PROPERTIES

The weld bead has good appearance and slag peels off easily. The weld metal is tough, extremely ductile, resistant to cracking and of radiographic quality.

PROCEDURE

Clean the area to be welded. Adopt short arc, on DC power source with reverse polarity. It is recommended to dry the electrode at 300°C for one hour before use to get better results.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-85
	3.2x350	100-140
	4.0x350	140-180
	5.0x350	170-220

TYPICAL APPLICATIONS

Used for joining and building up of low and medium carbon steels. Ideal for joining dissimilar sections, restrained joints and oil soaked parts, castings. Can also be used as a cushioning alloy under hardfacing deposits. Finds applications in pressure vessels, pipes, flanges, vehicle chassis, cross members, gun plates, heavy machinery parts, steel castings, C-frames, Hframes, crusher rotor discs, etc.



SPECIFICATIONS

ALLOY BASIS: Mn, Si, C



TECHNICAL DATA

UTS : 50-58 kgf/mm²
Elongation : 22-29%