

# LH 106



**ELECTRODE FOR HIGH STRENGTH AND  
EXTREME CRACK- RESISTANCE TO  
ALL STEELS**

## PROPERTIES

Soft-arc, smooth, defect-free ferritic-austenitic weld metal with approx. 30% ferrite content. High strength and crack-resistance. Deposit is work-hardening, shockproof and resistant to friction and corrosion. Easy to use at low currents and in all position.

## PROCEDURE

Clean the weld area thoroughly and prepare joint edges. Preheat high alloy and high carbon steel to about 200-250°C followed by slow cooling after welding. Hold short arc and adopt stringer bead technique. Hot peening is advisable on joints.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	1.6x250	25-35
	2.5x350	50-75
	3.2x350	70-110
	4.0x350	90-140
	5.0x350	140-180

## TYPICAL APPLICATIONS

Heavy machinery parts, earthmoving equipment parts, automobile springs, trunnions of cement mills, parts subject to heat, corrosion and impact. Joining and surfacing of high carbon, low and high alloy steels, tool steels, spring steels, manganese steels, case hardened steels, high speed steels, cast steels, difficult to weld steels and unidentified steels. Joining dissimilar steels. Surfacing of grooved rolls and repair of dropforge dies. Used as cushioning alloy under-hard deposits.



## SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn



## TECHNICAL DATA

UTS : 75-85 kgf/mm<sup>2</sup>  
Elongation : 22-26%