

LH 109



ELECTRODE FOR JOINING SS TO CARBON STEEL AND FOR DEPOSITING SS OVERLAYS ON CARBON STEEL

PROPERTIES

The electrode gives smooth, stable arc, easy to operate. The slag peels off easily leaving a smooth and shining bead. The dense bead makes surfacing work easy and fast. The weld metal is strong, ductile, tough and can resist impact very well.

PROCEDURE

Adopt shortest possible arc and recommended current only. Do not weave on stainless steel.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	80-110
	3.2x350	110-140
	4.0x350	120-150

TYPICAL APPLICATIONS

Used for joining stainless steels to carbon steels, low alloy steels, cast steels and austenitic manganese steel parts. Depositing stainless tough overlay on cast steel parts, austenitic manganese steel parts. Rebuilding of impellers, shafts, valve bodies, seats and turbine guide vanes to provide resistance to heat, erosion and corrosion.



SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn, Mo



TECHNICAL DATA

UTS : 55-65 kgf/mm²
Elongation : 30-35%