

LH 1106



AUSTENO-FERRITIC ALLOY STEEL
ELECTRODE FOR HIGH STRENGTH
AND CRACK-RESISTANT WELDS

PROPERTIES

Rutile flux coated electrode depositing Austeno-Ferritic, crack-resistant weld metal with approx. 25-30% ferrite. Smooth weld bead with clean edge. Excellent slag removal (self-peeling characteristic). Practically no spatter loss and under cuts.

PROCEDURE

Clean the joint thoroughly. Remove all fatigued or damaged metal. On thick walled work-piece make 90° U groove. Preheat if required according to the base metal. Adopt short arc with recommended current. Peen the bead and cool slowly to room temperature.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-80
	3.2x350	80-100
	4.0x350	110-140

TYPICAL APPLICATIONS

Most suitable for joining armour steel, Austenitic Manganese steel, cast steel, forged steel and stainless steel to carbon steel or steels of unknown composition. For surfacing of grooved rolls, springs, dies, punches, crowns, and repair of drop forged dies and also as a cushioning layer before hard facing.



SPECIFICATIONS

ALLOY BASIS: Cr, Ni, Mn



TECHNICAL DATA

UTS : 70-80 kgf/mm²
Elongation (L=4d) 30-32%