LH-ALLOY®

LH 106

LOW HEAT 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.

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

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.

TYPICAL APPLICATIONS

- Heavy machinery parts, earth-moving equipment parts, automobile springs, trunnions of cement mills, parts subject to heat, corrosion & 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 & unidentified steels.
- Joining dissimilar steels.
- Surfacing of grooved rolls and repair of drop-forge dies.
- Used as cushioning alloy under-hard deposits.

SPECIFICATIONS

ALLOY BASIS: Mn, Si, C

TECHNICAL DATA

UTS : 50-58 kgf/mm^2

Elongation : 22-29%

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