

LH 1105



EXTRA LOW HYDROGEN CONTROLLED ELECTRODE WITH GOOD DUCTILITY AND CREEP RESISTANCE

PROPERTIES

High-deposition-efficiency electrode, giving smooth arc and very low spatter loss and easy slag detachability. The weld metal meets X-ray and ultrasonic requirements. The weld beads are ductile, crack-resistant and easy to operate in all positions.

PROCEDURE

Adopt medium arc and recommended current only. 2x-3x weaving may be adopted wherever necessary.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-90
	3.2x350	90-130
	4.0x350	130-180
	5.0x350	190-220

TYPICAL APPLICATIONS

Very good for repair of cracks in kiln tyres. Kiln shell welding, under-carriage frames of heavy earth moving equipment, high pressure pipelines, sluice gates, boiler tubes and boiler plates where good creep resistance is necessary for welding German Steels HIV 15 Mo3, etc. The electrode can be used for welding low-alloy steels in thermal-power stations, especially for welding of tubes in heat-exchangers, welding carbon steels of unknown composition.



SPECIFICATIONS

ALLOY BASIS: Mn, Si



TECHNICAL DATA

UTS : 55-65 kgf/mm²
 Elongation : 25-30%
 Charpy v-notch impact strength
 140-200 J