

LH 1125

A NEW GENERATION AUSTENITIC
STAINLESS STEEL ELECTRODE WITH
SPECIAL FEATURES

PROPERTIES

Deposits are soft, stable arc, weld bead with fine ripples, free from undercutting. Weld deposit is fully austenitic with controlled ferrite content of 3-8%. Excellent resistance to inter-granular corrosion due to extremely low level of carbon contents (0.03%). Exceptional weld bead appearance with straight toe line and excellent wetting in fillet welds. (i.e. concave beads) with 5% extra weld bead length. Self-releasing slag with little or negligible spatter. No need for weld dressing or fettling. High quality weld deposit with radiographic performance in multi pass welds. Smooth spray metal transfer with AC or DC (+) operation. Can be used in horizontal, vertical-up and overhead positions. Weld deposit is flat / concave with consistent ripples and free from porosity.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-75
	3.2x350	80-110
	4.0x350	120-150

TYPICAL APPLICATIONS

This electrode is of ELC quality (Extra Low Carbon - 0.03%). For joining and surfacing on Corrosion-resistant, austenitic 18 Cr/8 Ni, 18/8/Mo steel except Sulphur-corrosion atmosphere. Also used on 316L-17 requirement.

PROCEDURE

Clean the area to be welded. Use LH 900 for gouging. Use tacks for good alignment and fit up of joints. Adopt stringer bead technique with short / frigid arc. Do not weave the electrode. Use DCEP on DC power source.



SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni, Mo



TECHNICAL DATA

UTS : 50-63 kgf/mm²
Elongation : 35-45%