

# LH 125

AUSTENITIC STAINLESS STEEL ACID-RESISTANT ELECTRODE FOR WELDING  
AISI 316, 316L

## PROPERTIES

The extra low carbon weld deposit, is highly corrosion resistant against strong chemical influence. Resistant against grain disintegration upto 300°C.

## PROCEDURE

De-grease and clean the area to be welded. For heavy thickness prepare a 60° included angle V. Fit up should be accurate for long joints. Weld at regular intervals and use jigs & fixtures to avoid distortion. Use DCRP (DC+) on DC Power Source for good ripple & finish. Stringer bead technique with shortest possible arc length is recommended.

## WELDING CURRENT

| CURRENT     | LENGTH  | AMPS    |
|-------------|---------|---------|
| AC / DC (+) | 2.5x350 | 50-70   |
|             | 3.2x350 | 80-100  |
|             | 4.0x350 | 100-140 |

## TYPICAL APPLICATIONS

Welding of Austenitic stainless steels, Cr-Ni- Mo steels of the type 18 Cr / 8 Ni+Mo (V4A, AISI 316, Ugine NSM 22, Avesta 832 SK, Soderfors 564, Sandvik OR 60, UHB stainless 24, etc.). Dyeing and dairy equipment, Chemical vessels, Brewery and food equipment.



## SPECIFICATIONS

ALLOY BASIS: Fe, Cr, Ni, Mo



## TECHNICAL DATA

UTS : 54-64 kgf/mm<sup>2</sup>  
Elongation : 30-40%