

# LH 128

AUSTENITIC ELECTRODE FOR WELDING  
HIGH ALLOY AND UNALLOYED STEELS

## PROPERTIES

All position electrode giving 25Cr/12Ni deposit. It provides high-tensile strength, excellent resistance to chemical corrosion and heat. Slag detachability is good, gives smooth arc, low spatter and smooth weld bead of radiographic quality.

## PROCEDURE

De-grease and clean the area to be welded. For heavy thickness prepare a 90° U groove. Fit up should be accurate for long joints. Weld at regular intervals and use jigs & fixtures to avoid distortion. Use DC+ on DC Power source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-75
	3.2x350	90-110
	4.0x350	120-150

## TYPICAL APPLICATIONS

For joining stainless steel to low alloy steels, carbon steels, surfacing on mild steel to improve wear resistance. Used for cladding purpose on carbon steel.



## SPECIFICATIONS

ALLOY BASIS: Fe, Ni, Cr, Si, Mo



## TECHNICAL DATA

UTS : 55-65 kgf/mm<sup>2</sup>  
Elongation : 30-40%