

LH 206

ELECTRODE FOR WELDING PURE COPPER

PROPERTIES

A light-coated electrode with a quiet, stable arc and easy to operate. The weld deposit has good corrosion resistance and high electrical conductivity.

PROCEDURE

Clean the weld zone thoroughly. Hold a short arc. Slight weaving assist welding. Preheat thick sections, heavy jobs of pure copper up to 800°C. Use higher current to start with, heat up the plate and then lower it to the recommended value. Use bigger diameter electrode wherever possible.

WELDING CURRENT

| CURRENT | LENGTH | AMPS |
|-------------|---------|---------|
| AC / DC (+) | 2.5x350 | 60-80 |
| | 3.2x350 | 90-130 |
| | 4.0x350 | 150-170 |

TYPICAL APPLICATIONS

Welding of deoxidized and tough-pitch or electrolytic copper. Fabrication of copper plants for chemical industries and for high electrical conductivity joints.



SPECIFICATIONS

ALLOY BASIS: Cu



TECHNICAL DATA

UTS : 18-24 kgf/mm²