

# LH 330 HC



FOR HK40, HK60 AND SIMILAR  
HEAT RESISTING ALLOYS

## PROPERTIES

Easy arc striking & slag removal. Evenly rippled shining bead. The weld deposits withstand temperatures upto 1200°C in continuous service. Creep rupture strength at working temperature is quite high.

## PROCEDURE

Use low current and hold short arc. Bevel the edges for 90° U groove. Chip the slag completely and slow cool to room temperature.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60- 80
	3.2x350	90-110
	4.0x350	120-150

## TYPICAL APPLICATIONS

For welding heat-resisting cast alloys, type HK 40, HK 60 used in fertilizer industry, oil refineries, petrochemical plants, etc.



## SPECIFICATIONS

ALLOY BASIS: Fe, Ni, Cr, Mn, C



## TECHNICAL DATA

UTS : 60-65 kgf/mm<sup>2</sup>  
Elongation : 25% min.