

LH 409



ELECTRODE FOR WELDING ALUMINIUM

PROPERTIES

Aluminium electrode with good strength.
Fast burning and easy to handle.

PROCEDURE

Clean the area to be welded. The electrode should mainly be used for welding in down-hand position holding medium arc. In order to achieve better bonding, thick work-pieces (section of over 10 mm thickness) should be preheated up to 200°C.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	70-90
	3.2x350	90-110
	4.0x350	120-150

TYPICAL APPLICATIONS

Aluminum electrode for repair welding wrought & cast aluminum alloys, filling cavities, welding cracks, surfacing worn or broken parts. Used in aluminum foundries, repair shops, automobile workshops.



SPECIFICATIONS

ALLOY BASIS: Al, Si



TECHNICAL DATA

UTS : 10-20 kgf/mm²
Elongation : 4-12%