

# LH 501

ELECTRODE FOR WELDING  
PURE NICKEL

## PROPERTIES

Weld deposit is porosity & crack free, good resistance against corrosion and oxidation. Works smoothly with negligible spatter, self-detachable slag and uniformly rippled bead. Shining weld bead of radiographic quality.

## PROCEDURE

Clean the area to be welded. Adopt short arc with stringer bead technique as far as possible. Dry the electrode prior to welding for 1 hour at 300°C. Use DCRP (DC+) for best results.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-75
	3.2x350	90-110
	4.0x350	110-140

## TYPICAL APPLICATIONS

Used for welding of pure nickel and nickel-plated steels. Overlay of nickel on steel. Joining copper and copper alloys with steel. Apparatus construction, chemical industry, valves and pipe lines.



## SPECIFICATIONS

Alloy Basis Ni, Ti, Al, Fe  
AWS / A 5.11 E Ni-1



## TECHNICAL DATA

UTS 41-45 kgf/mm<sup>2</sup>  
Elongation 20-25%