

LH 512



CUPPRO-NICKEL ELECTRODE
FOR SEAWATER CORROSION
RESISTANCE

PROPERTIES

The weld deposit is resistant seawater corrosion, free of porosity and crack-resistant. Good welding properties and slag removal is easy. Weld beads are uniform & shining.

PROCEDURE

Clean the affected area. Preheat sections more than 25 mm to 100°C. Bevel out 90° U with LH 900. Deposit stringer beads and chip slag between passes.

WELDING CURRENT

| CURRENT | LENGTH | AMPS |
|-------------|---------|---------|
| AC / DC (+) | 2.5x350 | 60-80 |
| | 3.2x350 | 90-100 |
| | 4.0x350 | 110-130 |

TYPICAL APPLICATIONS

Used for joining & cladding similar grades of copper-nickel alloys, with up to 30% nickel content. Shipbuilding, food industry, desalinization plants, refrigerators, heat exchanger, pumps, valves, pipelines, etc.



SPECIFICATIONS

Alloy Basis Cu, Ni, Ti, Mn
AWS / A 5.11 Cu Ni



TECHNICAL DATA

UTS 35-40 kgf/mm²
Elongation 20-26%