

LH 521 A

NICKEL BASED MOLYBDENUM BEARING
ELECTRODE FOR TOUGH, HEAT AND
CORROSION RESISTANT JOINTS

PROPERTIES

The electrode gives soft stable arc on low currents. Deposits have excellent resistance to scaling at high temperatures and corrosion resistance at both normal and elevated temperatures.

PROCEDURE

Clean the surface thoroughly so as to be free from rust, oil, grease, paint, etc. Use reverse polarity only. Maintain short arc. Adopt stringer bead or slight weaving technique. Prepare edges so that, the included angle is 90° U and root gap should be appropriate. Dry the electrode prior to welding for approx. 300°C for 1 hour. Fill the craters by dwelling or back whipping.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-80
	3.2x350	100-120
	4.0x350	120-140

TYPICAL APPLICATIONS

Electrode for all-position welding of nickel, inconel, monel, nickeliron- chromium alloys. HK alloys, stainless and heat resisting steels. For use on equipment and components made of pure nickel, for fabrication of corrosion resistant tanks and containers, heat exchanger, furnace components, etc.



SPECIFICATIONS

Alloy Basis Ni, Cr, Mn, Fe, Cb, Mo
AWS / A 5.11 Ni Cr Fe-2



TECHNICAL DATA

UTS 55-60 kgf/mm²
Elongation 30-35%