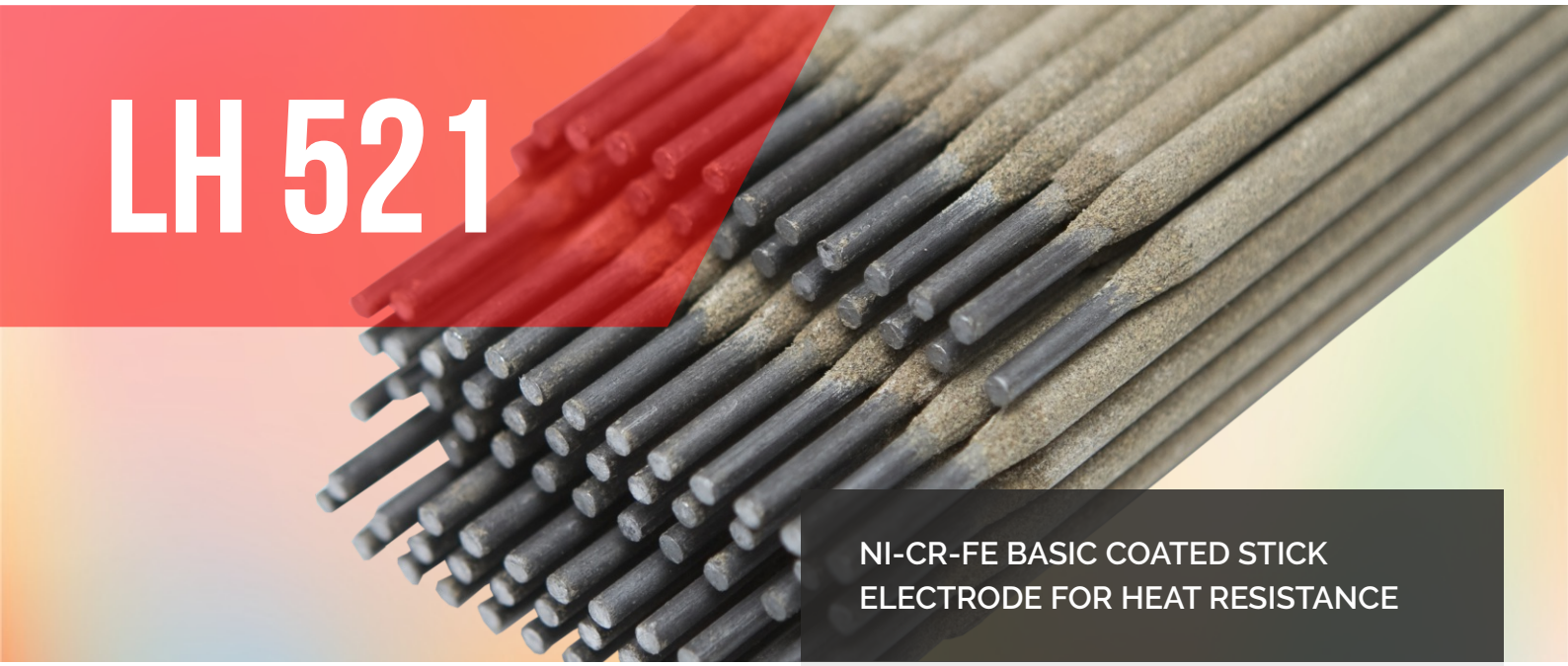
LH-ALLOY®

LH 521



NI-CR-FE BASIC COATED STICK ELECTRODE FOR HEAT RESISTANCE

PROPERTIES

The electrode gives soft stable arc on low currents. Deposits are smooth, tough and has excellent resistance to scaling, corrosion resistance at normal as well as elevated temperatures. Also possesses good thermal cycles and shock resistance. Any amount of buildup is possible. The deposit is tough and free from porosity.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	60-80
	3.2x350	90-110
	4.0x350	110-140
	5.0x350	140-160

PROCEDURE

Clean the area to be welded. Preheat sections above 25 mm to 100°C. Adopt short arc, stringer bead technique, chip the slag completely. Allow the job to cool slowly to room temperature.

TYPICAL APPLICATIONS

This is a versatile electrode for welding of nickel, inconel, monel, nickel-chromium-iron alloys. Weld deposits are similar to ENiCrFe3. HK alloys, steel, stainless steel and heat resisting steels. Also for welding dissimilar metals such as carbon steels, stainless steels, nickel, nickel alloys to each other. For use on equipment and components made of pure nickel, for fabrication of corrosion resistant tanks and containers, heat exchangers, furnace components, boilers, fittings, anchors, mill trunnions, symmetry gears, etc. Very good for repair of cracks in kiln tyres.

SPECIFICATIONS

Alloy Basis Ni, Cr, Mn, Fe, Nb
AWS / A 5.11 Ni Cr Fe-3

TECHNICAL DATA

UTS 55-60 kgf/mm^2
Elongation 30-35%

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