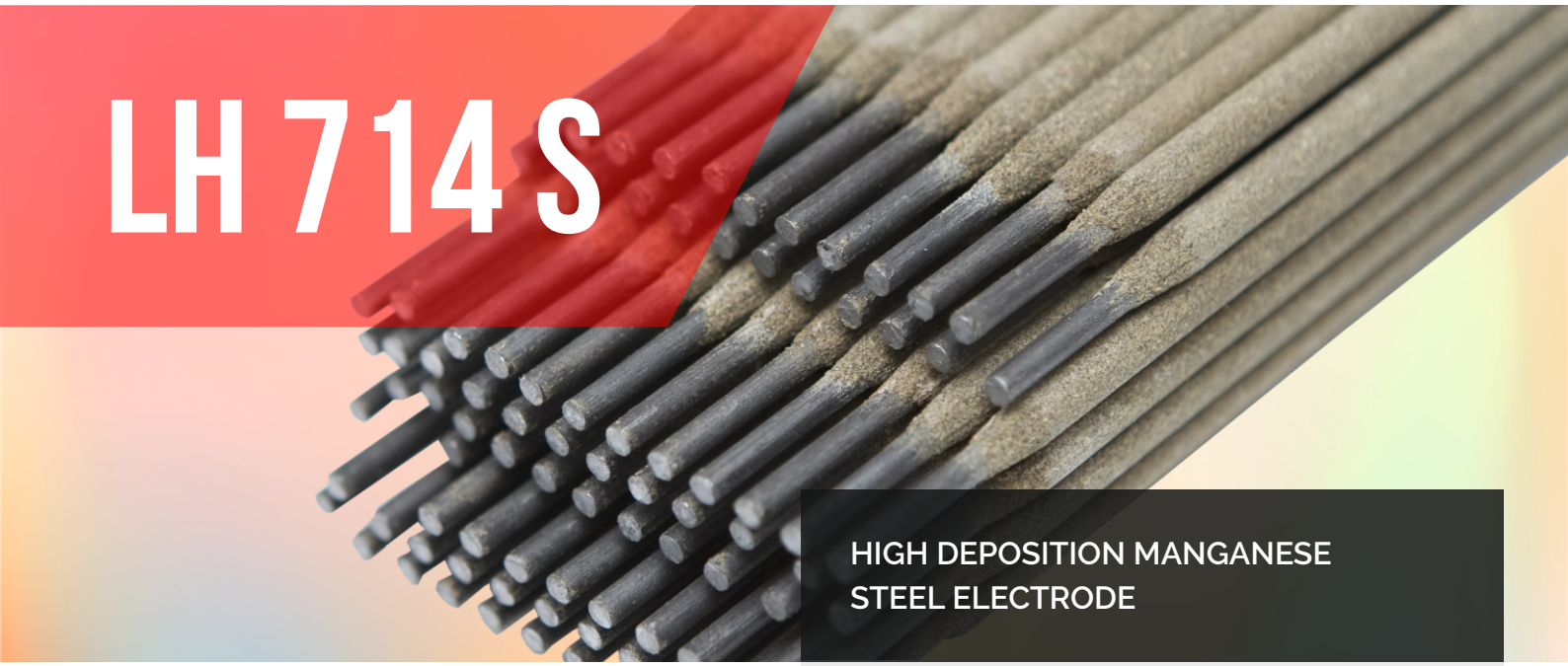
LH-ALLOY®

LH 714 S



HIGH DEPOSITION MANGANESE STEEL ELECTRODE

PROPERTIES

Work hardening type electrodewith very high deposition rate. Extremely ductile and hence ideal for intricate and hardened manganese steel parts. Has very fast work hardening tendency, high abrasion resistance and resistance to deformation and cracking.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	3.2x350	100-140
	4.0x350	120-170
	5.0x350	160-210

PROCEDURE

Ensure proper cleaning of the area to be welded. Remove the fatigue material by gouging using LH 900 or LH 902. Do not preheat Manganese Steel. Temperature should be kept below 150ºC using staggered or skip welding techniques. Hot peening helps reducing stresses. Small components can be immersed in water for controlling the temperature.

TYPICAL APPLICATIONS

For joining manganese steel parts, hard facing of parts subject to heavy impact and stress. For all position welding of 14% Mn steels, armour steels, carbon steels, Hadfield Steel. Ideal as buffer layers before surfacing on 14% Mn steels, hard or nidentified steels. Very thick build-ups possible without cracking. Specially developed for mining industry.

SPECIFICATIONS

ALLOY BASIS: Mn, Cr

TECHNICAL DATA

UTS 80-85 kgf/mm^2
Hardness as welded 17-20 HRC
work hardened 42-50 HRC
Metal Recovery 140%

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