

LH 718

ELECTRODE FOR ABRASIVE AND CORROSIVE CONDITIONS AT ELEVATED TEMPERATURES

PROPERTIES

Smooth and stable arc. Special alloy makes the weld resistant to impact, while retaining hardness at relatively elevated temperatures due to secondary hardening. Crack-free heavy buildups possible.

PROCEDURE

Preheat the work-piece to 250-300°C. Hold medium arc for weld deposition. Cool the job slowly to room temperature. Machining is possible only with Tungsten Carbide tools or grinding.

WELDING CURRENT

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

TYPICAL APPLICATIONS

For surfacing of blast furnace bells and hopper, tong pins, hot shears, etc. to resist severe abrasion especially at elevated temperatures.



SPECIFICATIONS

ALLOY BASIS: Mn, Ni, Mo



TECHNICAL DATA

Hardness 48-52 HRC
at 500°C 30-35 HRC