

LH 521

Ni-Cr-Fe basic coated stick electrode

ALLOY BASIS

Ni, Cr, Mn, Fe, Nb

PROPERTIES

The electrode gives soft stable arc on low currents. Deposits are cold tough and have excellent resistance to scaling at high temperatures and corrosion resistance at both normal and elevated temperatures. Also possesses good thermal shock resistance.

TECHNICAL DATA

UTS : 60 kgf/mm²
Elongation (L = 5d) : 35%

TYPICAL APPLICATIONS

This is a versatile electrode for all-position 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 and 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, etc.

PROCEDURE

Clean the workpiece thoroughly for a crack and porosity free deposit. Use short arc and ensure minimum heat input, using lowest possible amperage and using stringer bead technique. Slight weaving not exceeding 2-3 times the core wire diameter may be employed. Dry electrode for 2 hours at 300°C. To avoid crater cracks fill the craters properly.

WELDING CURRENT

Current : AC / DC (+)
Size (mm)/Length : 2.5x350 3.2x350 4.0x350
Current (amps) : 40-60 60-80 100-140



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