

LH 106 Electrode for high strength and extreme crack-resistance

ALLOY BASIS

Fe, Cr, Ni, Mn

PROPERTIES

- Soft-arc. Smooth and defect-free ferritic-austenitic weld metal with approximately 30% ferrite content.
- High strength and crack-resistance.
- Deposits resistant to friction, corrosion, work-hardening and shockproof.
- Easy to use at low currents and all position.

TECHNICAL DATA

UTS : 85 kgf/mm²
 Elongation : 24%

TYPICAL APPLICATIONS

- Heavy machinery parts, earth-moving equipment parts, automobile springs, trunnions of cement mills, parts subject to heat, corrosion and impact.
- Joining and surfacing of high carbon, low and high alloy steels, tool steels, spring steels, manganese steels, case hardened steels, high speed steels, cast steels, difficult to weld steels and unidentified steels.
- Joining dissimilar steels.
- Surfacing of grooved rolls and the repair of drop-forge dies.
- As a cushioning alloy under-hard deposits.

PROCEDURE

Clean the weld area thoroughly and prepare joint edges. Preheat high alloy and high carbon steel to about 200-250 °C followed by slow cooling after welding. Use short arc with stringer bead technique. Hot peening is advisable.

WELDING CURRENT

Current	: AC / DC (+)				
Size (mm)/Length	: 1.6x250	: 2.5x350	: 3.2x350	: 4.0x350	: 5.0x350
Current (amps)	: 25-35	: 40-75	: 70-110	: 90-140	: 130-180



Reclamation, Fusion
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