

## LH 126

Fully austenitic heat resistant stainless steel electrode

### ALLOY BASIS

Fe, Cr, Ni

### PROPERTIES

Fully austenitic, heat resistant deposit Heat resistant at working temperatures up to 1200 °C. in oxidizing, sulphur free atmosphere.

### TECHNICAL DATA

UTS : 65 kgf/mm<sup>2</sup>  
Elongation : 35%

### TYPICAL APPLICATIONS

Welding of austenitic stainless, heat resistant Cr-Ni steels of the type 25 Cr / 20 Ni (NCT, AISI 310, Ugine NS 30, Avesta 254 E, Sandvik 15 RE 10). Also suitable for welding of steels with high carbon content often used in the construction field. Furnace linings, furnace parts, burners, heat treatment pots and baskets.

### PROCEDURE

Clean and de-grease the area to be welded. For heavy thickness prepare a 60° included angle Vee. Fit up should be accurate for long joints. Weld at regular intervals and use jigs and fixtures to avoid distortion. Use DCEP (DC+) on DC Power Source for good ripple and finish. Stringer bead technique with shortest possible arc length is recommended.

### WELDING CURRENT

Current	: AC / DC (+)		
Size ( mm)/Length	: 2.5x350	3.2x350	4.0x350
Current (amps)	: 50-75	90-110	120-140



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