LOW HYDROGEN IRON POWDER ELECTRODE FOR 0.5% MOLYBDENUMSTEELS

EUTHERME LH – A1

CODING:

AWS: E 7018 A1
DIN : E kb Mo 26

CHARACTERISTICS:

Eutherme LH-A1is a heavy coated low hydrogen iron powder type electrode specially meant for welding carbon molybdenum creep resisting steels. The electrode operates well on AC as well as DC+ in all welding positions. The weld metal contains 0.5% molybdenum and the metal recovery is around 115%

USES:

is suitable for welding carbon molybdenum steels, medium and high tensile alloys steels, heat and creep resisting steels, boilers, pressure vessels, pipelines, heavy structural work, bridges, chemical storage tanks etc.

NOTED FEATURES:

1. Suitable electrode for welding creep resisting steels of high temp us.
2. Sound, defect free and radiographic quality weld metal.
3. Good burning characteristics on AC as well as DC+.
4. Fine rippled bead and easily removable slag.
5. Smooth and stable arc.

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.15 X 350	4.00 X 350	5.00 X 350
CURRENT-Amps	DC+/AC 70	60-100	100-140	140-190	200-260

CHEMICAL ANALYSIS OF THE WELD METAL:

Element	C	Mn	Si	Mo	S	P
%	0.12max	0.90max	0.80max	0.40-0.65	0.04max	0.03max

MECHANICAL PROPERTIES OF THE WELD METAL:

1. Ultimate Tensile Strength(N/mm^2) : 540-560
2. 0.2% Proof Stress (N/mm^2) : 460-480
3. Elongation(%) on 50mm gauge length : 26-28
4. Impact Strength(J)@ 27°C : 100-120

SPECIAL INSTRUCTIONS:

1. Keep electrodes absolutely free from moisture.
2. Rebake electrodes @ 350°C for one hour before use.
3. Use higher current for maximum recovery.
4. Use shorter arc for sound welding.