

## BASIC COATED - LOW HYDROGEN - IRON POWDER ELECTRODE



**CODING:** AWS/SFA-5.1 E 7018  
EN 499 E42 4 B32 H5

### CHARACTERISTICS :

**EUTHERME LH** is a basic coated low hydrogen iron powder electrode suitable for welding heavy structures, high tensile strength jobs where impact strength at sub-zero temperatures are required. With an increased metal recovery due to the presence of iron powder, enhances the welder to complete the job faster. The basic coated formulation ensures a defect-free radiographic quality weld. The superb and well established flux formulation ensure excellent performance of the electrode in AC/DC(+) in all welding positions except vertical down.

### ADVANTAGES :

- Uniform and soft metal transfer
- Easy to control weld pool and slag.
- Increased weld deposit of about 115% ensures faster welding.
- Neat weld profile in fillet joints.
- High tensile strength and excellent toughness in sub-zero temperatures.
- Suitable for highly restrained joints

### APPLICATIONS :

**EUTHERME LH** is suitable for all sorts of joining, repairing and fabrication of structural works medium and high tensile steels of grade 550 N/sqmm., The applications include; welding of Structures, highly restrained joints, bridges, railway coaches & wagons, plants, ships, tugs, barges, trawlers, dredgers, storage tanks, boilers, pipelines, grills etc.,

### CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.25 X 350	4.00 X 450	5.00 X 450
CURRENT Amps	AC / DC(+)	70-100	100-140	150-190	200-250

### TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	S	P	Mn+Ni+Cr+V
percent	0.07	1.00	0.54	0.016	0.020	<1.75%

### TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/sq mm.	UTS N/sq mm	% Elongation	CVN Impact value At -40°C
480	540	26	55J

**Diffusible Hydrogen Content** : 5 ml/100gms. of weld

**Radiographic evaluation** : Meets the requirements of Grade-I.

**Moisture content in the flux covering** : 0.6%

**Rebaking recommendations** : The electrodes should be re-baked at 350°C for one hour prior to use and maintained warm till the job is completed.