BASIC COATED - LOW HYDROGEN - IRON POWDER ELECTRODE

EUTHERME LH -1

CODING: AWS/SFA 5.1 – E 7018 - 1

CHARACTERISTICS : Basic electrode,particularly suitable for welding high strength low alloy steels, electrode has excellent welding properties, it has good slag removal and minimum spatter. The weld metal is very resistant to hot cracking, has good, low temp. impact strength and low hydrogen content. All welding positions except vertical down.

ADVANTAGES :

- Uniform and soft metal transfer
- Easy to control weld pool and slag.
- Suitable in DC (+) and in AC 70V.
- 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 :

Typical applications include welding of carbon steels sensitive to hydrogen embritlement, heavy and rigid structures pressure vessels and equipment subjected to severe stress and requiring good toughness,properties at sub zero temp. down to -50°C

CURRENT CONDITIONS:

SIZE mm		2.50 X 350	3.25 X 350	4.00 X 350	5.00 X 350
CURRENT - Amps	AC70 / DC(+)	70-100	100-130	150-190	200-250

TYPICAL CHEMICAL COMPOSITION OF WELD METAL

Element	C	Mn	Si	Cr	Mo	Ni	V
percent	0.10max	1.40	0.60	0.10	0.15	0.25	0.05

TYPICAL MECHANICAL PROPERTIES OF THE WELD METAL

Y.S. N/sq mm.	U T S N/sq mm	% Elongation	CVN Impact value At -40°C
460	530	26	60J

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 400°C for one hour prior to use and maintained warm till the job is completed.