

ROWELD-HF II LH

BASIC COATED LOW HYDROGEN TYPE HARD FACING
ELECTRODE

BASIC ALLOY: C, CR, FE
DIN-8555: E1 -UM-400-S

KEY FEATURES:

A high Nickel alloy electrode specially designed to resist crack, oxidation and corrosion. Equally provides high strength at elevated temperature. Gives smooth arc, excellent operating characteristics, easy slag detachability.

APPLICATIONS

- A medium-heavy coated hydrogen controlled electrode for hard facing applications on mild steel, carbon steel and low alloy steel where approximately 300 Brinell hardness is required. The weld deposit is machinable with carbide tools

RE-DRY CONDITION:

- Re-Dry the electrode at 250°C for one hour.

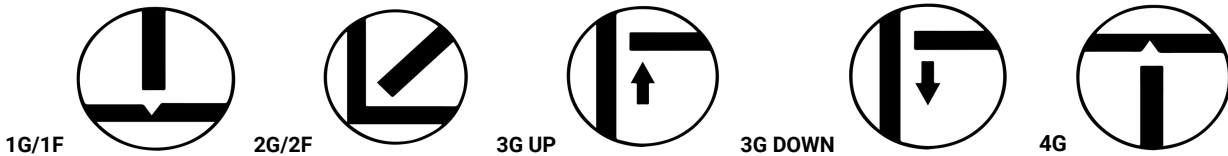
CHEMICAL COMPOSITION:

C	Mn	Si	Cr
0.20-0.40	1.00 Max	0.60 max	2.50-3.50

MECHANICAL PROPERTIES:

Hardness
350-400 BHN

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm) (Dia)	Size (inch) (Dia)	Current Condition (DC+ / AC) Amps	Kg/pkt.	Kg/Case
3.15 / 3.20	1 / 8"	100-130	5	20
4.00	5 / 32"	150-180	5	20
5.00	3 / 16"	210-260	5	20