

## LH 714 S

High deposition manganese steel electrode

### ALLOY BASIS

Mn, Cr

### PROPERTIES

Work hardening type electrode with very high deposition rate. Extremely ductile and hence ideal for intricate and hardened manganese steel parts. Has very fast work hardening tendency, high abrasion resistance and resistance to deformation and cracking.

### TECHNICAL DATA

UTS	:	80-85 kgf/mm <sup>2</sup>
Hardness as welded	:	17-20 RC
	work hardened	: 42-50 RC
Metal recovery	:	140%



### TYPICAL APPLICATIONS

For joining manganese steel parts, hardfacing of parts subject to heavy impact and stress. For all position welding of 14% Mn steels, armour steels, carbon steels, Hadfield Steel. Ideal as buffer layers before surfacing on 14% Mn steels, hard or unidentified steels. Very thick build-ups possible without cracking. Specially developed for mining industry.

### PROCEDURE

Ensure proper cleaning of the area to be welded. Remove the fatigue material by gouging using LH 900 or LH 901. Do not preheat Manganese Steel. Temperature should be kept below 150 °C using staggered or skip welding techniques. Hot peening helps reducing stresses. Small components can be immersed in water for controlling the temperature.

### WELDING CURRENT

Current	:	AC / DC (+)		
Size (∅ mm)/Length	:	3.2x350	4.0x350	5.0x350
Current (amps)	:	100-140	120-170	160-210



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