



SILOX Fe LH

C-Mn STEEL (Special Purpose)



Hydrogen Controlled Electrode for Welding of Hot Dip Galvanizing Baths

KEY FEATURES :

- Basic type heavy coated
- Controlled Hydrogen content
- Deposit pure iron with low impurities
- Low Silicon content
- Strong & ductile weld
- Weld metal is resistant to corrosion by molten Zinc & Lead

WELDING POSITION :



AC (70 OCV)/ DCEP

TYPICAL APPLICATIONS :

- Welding and repairing of hot dip galvanizing baths

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	S	P
Typical	0.05	0.5	0.03	0.02	0.02
Specification	0.08 max	0.3-0.8	0.04 max	0.03 max	0.03 max.

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 27°C, J
Typical	As Welded	475	400	25	64
Specification		440-520	350-445	22-27	50-80

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
3.15 x 450	90-130	128	4	39
4.0 x 450	140-180	82	4	61
5.0 x 450	180-220	51	4	98