

SILOX Fe (LH)

CLASSIFICATIONS

IDENTIFICATION: Name Printed

CHARACTERISTICS

A heavy coated, hydrogen controlled basic flux covered electrode with soft arc, easily detachable heavy slag and low spatter. Weld deposits almost pure iron with low impurities and is fairly strong and ductile. The weld beads are smooth and shining. Weld metal is made resistant to corrosion by molten, zinc and lead. The electrode deposits weld metal have X-ray quality.

TYPICAL APPLICATIONS

Specially designed for welding and repairing of hot dip galvanising baths which calls for electrode low in silicon.

CURRENT CONDITIONS: DC+, AC (70V)

5.0	4.0	3.2
180-220	140-180	90-130

WELDING POSITIONS

F, H, OH, Vup

REDRYING: Redry at 300°C for 1 hr.

WELD METAL CHEMISTRY, (%)

C	-	0.08 max	S	-	0.03 max
Mn	-	0.30-0.80	P	-	0.03 max
Si	-	0.04 max			

MECHANICAL PROPERTIES - ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)	CVN Impact, J 27± 2°C
As-welded	440-520	350-445	22-27	50-80

PACKING DATA

Dia., mm	5.0	4.0	3.2
Length, mm	450	450	450
Pcs per carton, Nos	51	82	128
Cartons / box	4	4	4
Pcs per box, Nos	204	328	512
Approx. Wt. of 1000 pcs,kg	98	61	39



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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