



BOILERON-LH

HIGH TENSILE STEEL ELECTRODE

CLASSIFICATION :

IS : 1395-82 : E 63B-D129

CHARACTERISTICS :

A basic coated electrode designed for the welding of high tensile steels, molybdenum bearing steels and other low alloy steels. The easy slag removal, low spatter, uniform bead shape, smooth and regular fusion are some of the salient features.

APPLICATIONS :

- * Penstocks, Pipes
- * Quenched and Tempered steels.
- * Structural Steels of high strength such as ST 60 and ST 70

RECOMMENDATIONS :

Re-dry the electrodes at 350°C for one hour or at 250°C for two hours. Keep the redried electrodes in a holding oven at 120°C-150°C. Preheating and post heating should be strictly followed as per the recommendation of steel manufacturer. Use short arc and stringer bead technique. Control the interpass temperature below 120°C.

CHEMICAL ANALYSIS
OF WELD-METAL(%) :

C	Mn	Si	Mo	S	P
0.10 max	1.25-1.75 max	0.80 max	0.25-0.45	0.03 max	0.03 max

MECHANICAL PROP-
ERTIES OF ALL WELD-
METAL (AS PER
IS: 1395-82) :

Yield Strength	Ultimate Tensile Strength	Elongation (GL=5d) (%)	Reduction in Area (%)	CVN Impact Values at -51°C/27°C Joules
N/mm ² 530-600	N/mm ² 630-700	18-25	40-60	27/90

CURRENT CONDITIONS : USE DC (+) OR AC (90V)

Size (mm)	3.15x450	4.0x450	5.0x450
Amps	100-130	150-180	180-220



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