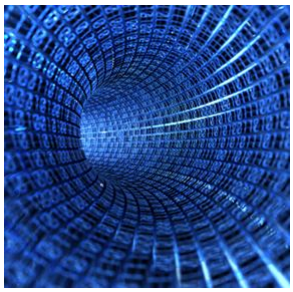
Lehami 7307



Universal all position mild steel electrode

SPECIAL FEATURES

- Only mild steel electrode offering the convenience of flat, vertical up and down, and overhead without changing amperage setting.
- Electrode can be bent without flux breakage.
- Contact (drag) type transfer allows the electrode to weld by itself.

APPLICATIONS

Versatile all around repair and fabrication of clean, well-fitting common mild steel components. Fast freeze slag characteristics ensures fully positional operability.

AVAILABLE SIZES

INCHES	*METRIC*	*GAUGE*	*RECOMMENDED AMPERAGE*
1/16”	**1.6 mm**	**16**	**20 - 40**
5/64”	**2.0 mm**	**14**	**30 - 50**
3/32”	**2.5 mm**	**12**	**50 - 70**
1/8”	**3.2 mm**	**10**	**70 - 110**
5/32”	**4.0 mm**	**8**	**115 - 140**
3/16”	**5.0 mm**	**6**	**150 - 200**

RECOMMENDED CURRENT: DC Straight polarity (Electrode -), Reverse polarity (Electrode +) or AC

WELDING POSITIONS: Flat, Vertical Up, Vertical Down, Horizontal, Overhead

WELDING TECHNIQUES:

Hold a short to medium arc length, lean electrode 45º towards the direction of travel. Use either the stringer or weave technique.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	**Maximum Value Up to:**
Tensile Strength as welded	83,000 psi (600 N / mm^2)
Yield Strength	75,000 psi (540 N / mm^2)
Elongation	25%
Impact Energy	90 Joules: -4ºF (-20ºC)

WELD METAL ANALYSIS (Typical Weight,%)

C	Fe	Mn	P	S	Si
0.08	Bal	0.50	0.02	0.01	0.20

DEPOSITION RATES

Diameter	*Length*	*Weldmetal / Electrode*	*Electrodes per lb (kg) of Weldmetal*	*Arc Time of Deposition in Minutes per lb (kg) of Weldmetal*
1/16" (1.6 mm)	12" (300 mm)	0.11 oz (3 g)	145 (320)	57 (125)
5/64" (2.0 mm)	12" (300 mm)	0.14 oz (4 g)	114 (251)	47 (103)
3/32" (2.5 mm)	14" (350 mm)	0.30 oz (8 g)	53 (117)	36 (79)
1/8" (3.2 mm)	14" (350 mm)	0.62 oz (17 g)	26 (57)	25 (55)
5/32" (4.0 mm)	14" (350 mm)	1 oz (28 g)	16 (35)	20 (44)
3/16" (5.0mm)	14" (350 mm)	1.5 oz (42 g)	11 (23)	14 (31)

INTERNATIONAL SPECIFICATIONS	**AWS/ASME A5.1: E 6013**	**EN 499: E 420 RC 11**
	DIN 1913: E 5122 R (C) 3	**ISO 2560: E 51.2RR22**
	NFA 81-309: E 512/2 R 12	**BS 619: E 5122 R 12**