

# Lehami 7393

## Special Vertical Position Stainless Steel Electrode



### SPECIAL FEATURES

- Unique “Fast-Freeze” coating simplifies vertical down and up welding.
- Ideal for poor fit up joints in all positions.
- Controlled weld puddle allows for filling holes on stainless steels.

### APPLICATIONS

Especially suited for vertical down and up welding of thin to medium gauge molybdenum bearing stainless steel.

### AVAILABLE SIZES

INCHES	METRIC	GAUGE	RECOMMENDED AMPERAGE
5/64"	2.0 mm	14	35 - 55
3/32"	2.5 mm	12	60 - 80
1/8"	3.2 mm	10	90 - 110

**RECOMMENDED CURRENT:** DC Reverse polarity (Electrode +) or AC

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

### WELDING TECHNIQUES:

For vertical welding, set amperage at high end of the scale. Maintain a sharp angle with the electrode pointing upward. Whip the electrode quickly back and forth while moving up or down. Electrode may show a red color from the excess amperage which is normal.

**TYPICAL MECHANICAL PROPERTIES**

**Undiluted Weld Metal**

**Maximum Value Up to:**

Tensile Strength as welded	80,000 psi (550 N / mm <sup>2</sup> )
Yield Strength	56,000 psi (390 N / mm <sup>2</sup> )
Elongation	42%
Impact Energy	40 Joules: -157°F (105°C)
Hardness	Brinell 209, Rockwell B 96

**MICROSTRUCTURE:**

Austenite with 3-9% ferrite. Typical ferrite number is 6.

**DEPOSITION RATES**

<i>Diameter</i>	<i>Length</i>	<i>Weldmetal / Electrode</i>	<i>Electrodes per lb (kg) of Weldmetal</i>	<i>Arc Time of Deposition in Minutes per lb (kg) of Weldmetal</i>	<i>Recovery Rate</i>
5/64" (2.0 mm)	12" (300 mm)	0.14 oz (4 g)	114 (251)	47 (103)	100 %
3/32" (2.5 mm)	12" (300 mm)	0.36 oz (11 g)	40 (88)	35 (76)	100 %
1/8" (3.2 mm)	12" (300 mm)	0.60 oz (17 g)	25 (57)	21 (46)	100 %

**WELD METAL ANALYSIS (Typical Weight)**

C	Cr	Cu	Fe	Mn	Mo	Ni	P	S	Si
0.018	19	0.10	Bal	0.9	2.65	12	0.02	0.01	0.75

<b>INTERNATIONAL SPECIFICATIONS</b>	AWS/ASME A5.4: E 316L-16	EN 1600: E 19 12 3 LR 3 1
	DIN 8556: E 19.12.3 LR 16	ISO 3581: E 19.12.3 LR 16
	NFA 81-343: EZ 19.12.3 LR 16	