

Lehami 7401

Economical hardfacing electrode for abrasion and moderate impact



SPECIAL FEATURES

- The best hardfacing electrode for low open circuit voltage AC welding machines.
- Spray transfer allows for smooth, uniform overlays.
- Hardness of RC 56-58 allows for good abrasion resistance along with moderate impact resistance.

APPLICATIONS

General hardfacing where some impact is combined with abrasion.

AVAILABLE SIZES

INCHES	METRIC	GAUGE	RECOMMENDED AMPERAGE
1/8"	3.2 mm	10	100 - 130
5/32"	4.0 mm	8	150 - 190
3/16"	5.0 mm	6	200 - 260

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

WELDING POSITIONS: Flat, Horizontal

WELDING TECHNIQUES:

Weld deposits are best applied using a weave technique. Full undiluted hardness is usually achieved after 2 to 3 passes.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Hardness

Wear Co-efficient

Maximum Value Up to:

Rockwell C 56 - 58

2.8 %

MICROSTRUCTURE:

In the as-deposited condition, the microstructure consists of martensite and some carbides.

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>
1/8" (3.2 mm)	14" (350 mm)	0.9 oz (26 g)	18 (39)	23 (50)	130 %
5/32" (4.0 mm)	14" (350 mm)	2.5 oz (28 g)	6 (14)	17 (37)	130 %
3/16" (5.0mm)	14" (350 mm)	3.7 oz (105 g)	4 (9)	13 (29)	130 %

WELD METAL ANALYSIS (Typical Weight, %)

C	Cr	Fe	Mn	Mo	Ni	P	S	Si
0.56	5.7	Bal	0.95	0.63	0.03	0.018	0.014	0.43

INTERNATIONAL SPECIFICATIONS	AWS/ASME None
	DIN 8555 E6-UM-60-GP