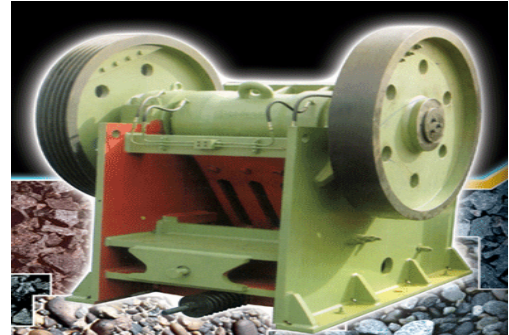


Lehami 7402

Joining and cladding electrode for manganese steel that can be flame cut



SPECIAL FEATURES

- Spray transfer allows for smooth uniform overlays.
- Work hardens easily in service.
- Rare alloy that can be flame cut.

APPLICATIONS

For repair of rail equipment and construction equipment manufactured of manganese steel.

AVAILABLE SIZES

INCHES	METRIC	GAUGE	RECOMMENDED AMPERAGE
1/8"	3.2 mm	10	90 - 125
5/32"	4.0 mm	8	125 - 170
3/16"	5.0 mm	6	160 - 225

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

WELDING POSITIONS: Flat, Horizontal, Vertical Up, Overhead

WELDING TECHNIQUES:

Clean metal of oil and fatigued sections. Do not allow weld interpass temperature to exceed 500°F (260°C).

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength as welded

Elongation

Reduction of Area

Impact Energy

Hardness (As welded)

Hardness (Worked)

Maximum Value Up to:

116,000 psi (800 N / mm²)

38%

25%

50 Joules: 68°F (20°C)

Brinell 170 - 220, Rockwell B 87 - 96
Vickers 180 - 230

Brinell 380 - 550, Rockwell C 41 - 54
Vickers 400 - 580

MICROSTRUCTURE:

In as-deposited condition the microstructure consists of a soft manganese alloy austenite which rapidly work hardens under impact loading.

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)	0.94 oz (26 g)	17 (38)	24 (53)	120 %
5/32" (4.0 mm)	14" (350 mm)	1.45 oz (41 g)	11 (24)	19 (42)	120 %
3/16" (5.0mm)	14" (350 mm)	2.3 oz (64 g)	7 (16)	13 (29)	120 %

WELD METAL ANALYSIS (Typical Weight,%)

C	Cr	Fe	Mn	Ni	P	S	Si
0.60	3.75	Bal	16.0	3.65	0.015	0.01	0.08

INTERNATIONAL SPECIFICATIONS	AWS/ASME None
	DIN 8555 E7-UM-200/50-KP