

Lehami 7405

Highly Resilient Build-Up Electrode
depositing weldmetal that resists extreme
compressive stresses.



SPECIAL FEATURES

- Very tough alloy for underlayments or medium hard tough overlays.
- Excellent machinability
- Excels in vertical and horizontal position welding.

APPLICATIONS

For underlayments on carbon and low alloy steels, also as a stand alone overlay for medium hard tough build-ups on rails, shafts, etc.

AVAILABLE SIZES

INCHES	METRIC	GAUGE	RECOMMENDED AMPERAGE
1/8"	3.2 mm	10	100 - 140
5/32"	4.0 mm	8	140 - 180
3/16"	5.0 mm	6	180 - 230

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

WELDING POSITIONS: Flat, Horizontal, Vertical Up

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Hardness

Maximum Value Up to:

Brinell 270, Rockwell C 25 - 27

MICROSTRUCTURE:

Martensite with 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>
1/8" (3.2 mm)	18" (450 mm)	0.77 oz (22 g)	20 (44)	21 (47)
5/32" (4.0 mm)	18" (450 mm)	1.33 oz (39 g)	12 (26)	18 (39)
3/16" (5.0mm)	18" (450 mm)	2.34 oz (65 g)	7 (15)	13 (28)

WELD METAL ANALYSIS (Typical Weight, %)

C	Cr	Fe	Mn	Mo	Ni	P	S	Si
0.22	0.50	bal	0.90	0.60	0.70	0.01	0.012	0.50

INTERNATIONAL SPECIFICATIONS	AWS - None
	DIN 8555 E1-UM-250