

# LH 715



ELECTRODE WITH HIGH  
SPEED STEEL DEPOSIT

## PROPERTIES

Basic coated electrode with excellent characteristics. The beads are fine-drawn and regular. The slag can be easily removed. The deposit is high quality tool steel; tough, hard, wear and oxidation resistant, free from cracks and porosities.

## PROCEDURE

Preheat larger and intricate sections between 300-600°C and maintain the same during welding. Smaller jobs need not be preheated since the arc temperature does the needful. Chip slag between passes and peen to reduce residual stresses for heavy deposits. Use LH 1061 as a cushioning alloy. Limit the buildup to 3 layers. Slow cool the job using an oven or asbestos.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-80
	3.2x350	90-100
	4.0x350	110-130
	5.0x350	160-210

## TYPICAL APPLICATIONS

For repair and manufacture of cold and hot cutting tools, trimming dies, broaches, punching tools, drills, milling tools, hot dies, etc.

## HEAT TREATMENT

Annealing 4 hours at 820°C

Hardening 1180°-1230°C, quenching in oil

Tempering Two hours at 540-560°C



## SPECIFICATIONS

ALLOY BASIS: Mo, Cr, W, V



## TECHNICAL DATA

Hardness as welded 59-61 HRC  
work hardened 62-64 HRC  
annealed 25-30 HRC