



# SILOX Fe LH

C-Mn STEEL (Special Purpose)

### KEY FEATURES:

- Basic type heavy coated
- Controlled Hydrogen content
- Deposit pure iron with low impurities
- Low Silicon content
- Strong & ductile weld
- Weld metal is resistant to corrosion by molten Zinc & Lead

### TYPICAL APPLICATIONS:

- Welding and repairing of hot dip galvanizing baths


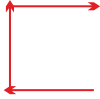
### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.05	0.6	0.06

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 27°C, J
Typical	As Welded	475	400	25	64
Specification		415 min	350 min	22 min	50 min

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
3.15 x 450	90-130	 <b>DCEP</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
4.0 x 450	140-180		
5.0 x 450	180-220		

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing