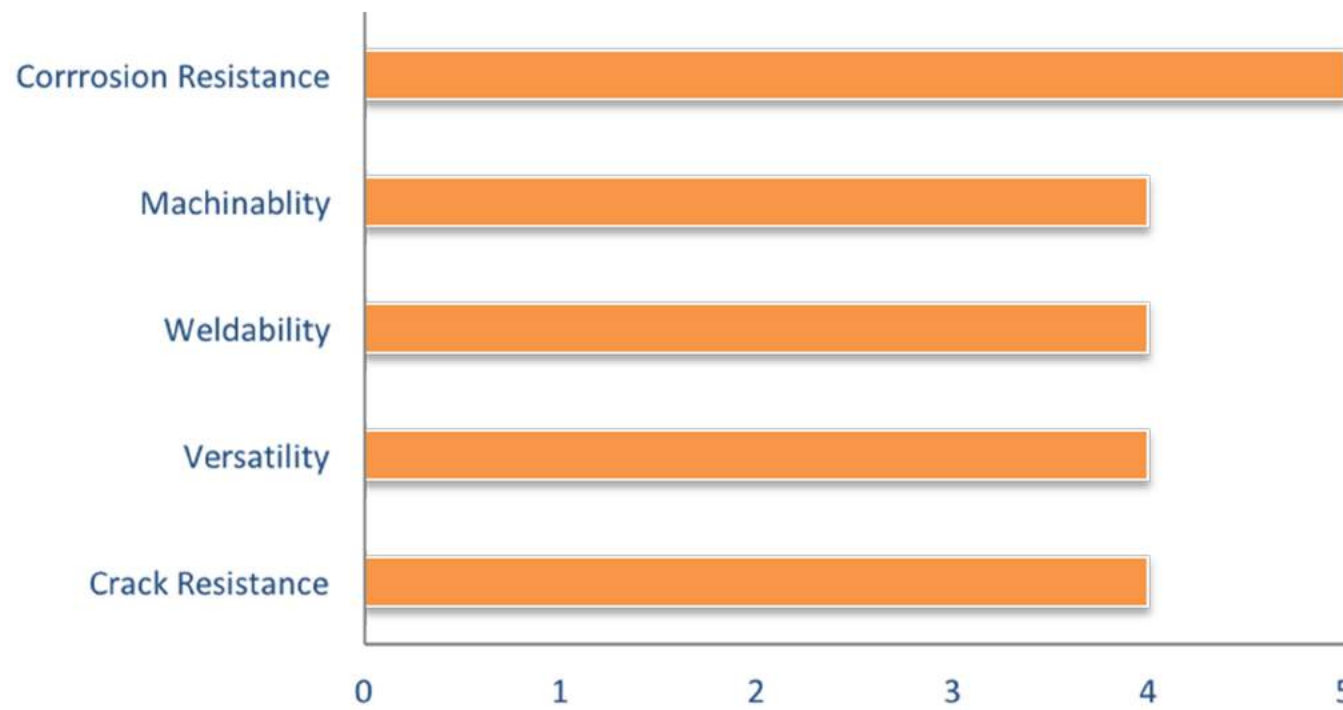




**Ideal for
Welding
Bronze and
Dissimilar
Metals**



Tensile Strength:
51,000 Psi

Hardness:
As Deposited: 70-80 RB
Work Hardened: 90-100 RB

Unialloy LH 280

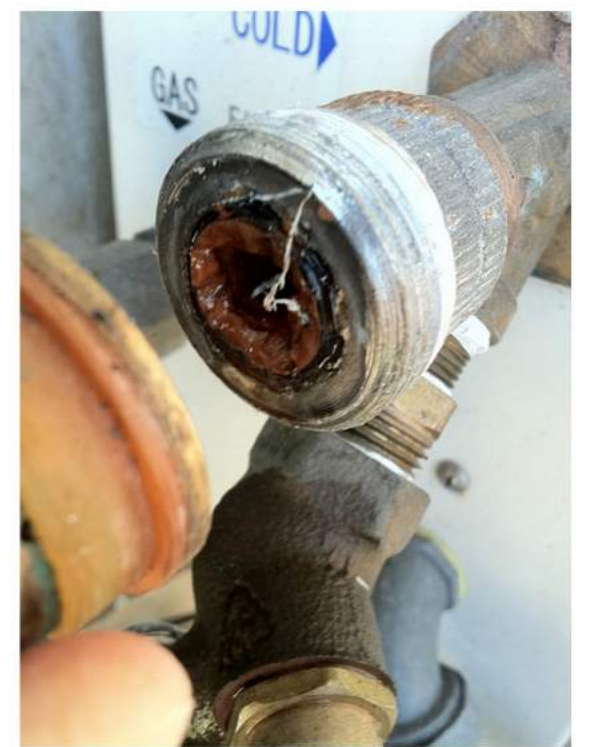
ac/dc+

KEY FEATURES

- Good Crack Resistance.
- Highly Versatile.
- Excellent Weldability on ac/dc in all positions.
- Deposits are machinable & have good resistance to salt water & steam corrosion.

TYPICAL APPLICATIONS

- Marine Components.
- Pump Impellers.
- Slow Speed Gear Teeth.
- Castings.
- Dissimilar Metals.



APPLICATION PROCEDURE

Remove damage metal by chiseling and clean the weld area. Bevel edges at 90°. Preheat heavy section to 100°-250°C. Deposit thin stringer beads using short arc. Peen the deposit and allow to cool down slowly.



WELDING PARAMETERS

Size (in mm)	4.00	3.15
Current (in Amp)	90-140	80-120

