

AWS E 7048
 DIN E 51 43 B 9
 EN E 42 2 B 15 H10

MLHV

For vertical downward welding of 50kgf/mm² class high tensile strength steel

Applications

Vertical downward welding of ships, buildings and bridges.

Characteristics

MLHV is a low hydrogen type electrode for exclusively vertical downward welding. Mechanical properties and crack resistibility of weld metal are good and slag is self – lifting. As higher amperage can be used, the efficiency of vertical welding is remarkably improved compared with vertical upward welding.

Notes on usage

1. Manipulate the electrode straight downward without weaving and press its tip against the mother plate.
2. Dry the electrodes at 300–350 °C for about 60 minutes before use.
3. Keep the arc as short as possible.
4. Adopt back step method or strike the arc on a small steel plate prepared for this particular purpose to prevent blowholes at the arc starting.

Typical chemical composition of weld metal (%)

C	Mn	Si
0.08	1.1	0.6

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %
> 420	500–640	> 20

Size & recommended current range: (~ =+ for 3.25) (~ =- for 4.00 & 5.00)

Product name	Order number	Diameter (mm)	Length (mm)	Amp.
MLHV	332543	3.25	350	90–130
	332544	4.00	450	140–200
	332576	5.00	450	220–270