



# Hard Facing Electrodes

## ALPHA HARD - II (LH)

### Characteristics

**ALPHA HARD - II (LH)** is a medium heavy coated, basic type, hydrogen controlled electrode for hard facing applications on mild steel, carbon steel and low alloy steels where hardness requirement is approximately 300 BHN. The weld metal is machinable with carbide tools.

### Applications:

Hot & cold punching dies, Shear blades, Brake shoes, rail ends & crossings, Conveyor parts, Steel castings, Pulleys and Axles etc

### Typical Weld metal Composition

Element	Percent
C	0.20-0.30
Mn	0.25-0.50
Si	0.50-0.75
Cr	0.85-1.25

**Hardness: 300-350 BHN on 3rd layer deposit.**

### Current Range & Packing Data :

Size MM DxL	Current Range (Amps) AC(70V) or DC (+)	Pieces per Packet	Pieces per Carton
5.00x450	180-240	45	180
4.00x450	140-180	80	320
3.15x450	100-140	110	440

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