



LQ257

CLASSIFICATION:

EN14700 DIN 8555
T Fe9 MF 7 200-KNP

CHARACTERISTICS

LQ257 is open arc or gas shielding flux cored wire, it is "hardfield" manganese type alloy, austenitic deposit is tough, crack free and work harden, keep cool during welding, do not preheating, keep interpass temperature as low as possible. Deposit can be multi-layered.

APPLICATION

Crushers, swing hammers, manganese dredge components such as buckets and tumblers, railroad sections, bucket teeth and lips, repair manganese steel castings.

TYPICAL ALL WELD METAL ANALYSIS

C	Mn	Si	Cr	Fe
1.0	14	0.4	4.0	Bal.

Hardness: >200HB Recovery: over 90% Welding Position: Flat

PARAMETER

Diameter	Voltage	Amps
1.2mm	25-29V	180-280A
1.6mm	25-29V	220-300A
2.0mm	27-31V	250-350A
2.4mm	28-31V	300-400A
2.8mm	28-32V	350-450A

PACKING

1.6mm: 15kg/spool
Over 2.0mm: 25kg/Coil, 50kg/Coil 250kg/Drum

Remark: Chemical composition and hardness are tested according to prescribed standard, actual results might be vary depending on many factors, like weld procedure, temperature etc, please contact our sales before use it in the intended application.