



## D&H 45S

### CHARACTERISTICS AND APPLICATIONS:

D&H 45S is a special purpose electrodes depositing almost pure iron weld metal which is ideally suited for welding galvanizing baths. The very low silicon content ensures excellent resistance to corrosion by molten zinc. Typical applications include welding of galvanizing baths and filling up of worn out bodies of galvanizing bath to resist corrosion by molten zinc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si
Percent	:	0.06	0.20	0.18

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L= 4d)%
408	30.0

### CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	:	5x450	4x450	3.15x450
Dia x Length				
Current Range	:	200-240	160-180	110-135
(Amps)				
Weight/Carton	:	4	4	4
(kgs)				

### PRECAUTION:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 150°C for one hour.

**NOTE :** The low hydrogen version **D&H 45S(LH)** is also available.