



TEXAS * PENNSYLVANIA * NORTH CAROLINA
<http://hi-alloy.com>

HI-ALLOY LO-HY PLUS

UNSURPASSED LOW HYDROGEN STRUCTURAL STEEL ALLOY

DESCRIPTION: Hi-Alloy Lo-Hy Plus is an electrode for all position welding designed with a special highly moisture resistant flux which results in superior weld deposit density and X-Ray quality welds. It offers outstanding performance and arc stability on either DC Reverse or AC polarity resulting in very finely rippled crack resistant beads.

TYPICAL APPLICATIONS: Cast steels, shipbuilding steels, tramp steels, boiler plate, pipe steels, construction steels, fabrication steels, and structural steels.

PROCEDURES: Clean the weld area in accordance with good welding practice. Heavy sections should be preheated to 300° - 500° F, maintain a short arc length, for vertical up welding use a slight weave technique pausing at the edges of the weld. Thoroughly remove slag between passes. Allow finished part to cool slowly in still air.

AVAILABLE SIZES:	3/32	1/8	5/32	3/16
AMPERAGE RANGES:	65 - 100	100 - 140	140 - 190	190 - 250
POLARITY:	DC Reverse or AC			
TENSILE STRENGTH:	Up to 84,000 psi			
YIELD STRENGTH:	Up to 70,000 psi			
ELONGATION:	Up to 32%			
IMPACT RESISTANCE:	90 Joules at -22° F			