

Black Glass Lo-Hi #104 The Maintenance Low-Hydrogen Electrode

Finally, a low-hydrogen rod designed for maintenance! The Black Glass Lo-Hi #104 features a special Chem-A-Tized² flux coating that produces a slag that consumes contaminants like lava — including rust, grease, dirt and paint. The low hydrogen coating makes the weld deposit tough and strong, yet still machinable.

- Superior cleaning action – the Black Glass slag consumes contaminants like lava
- Low-hydrogen toughness – designed for tough maintenance applications
- Special double-coated Chem-A-Tized² coating provides better arc control, low spatter and better bead appearance. It has the cleaners in the outside coating and the arc stabilizers on the inside, where they're needed to improve performance
- Operates on AC or DCEP
- Easy to use in all positions whether uphill, horizontal or overhead
- Designed to operate at lower amperage — reduced distortion and burn-through



SPECIFICATIONS

Tensile strength.....	Up to 87,000 psi/600 MPa
Yield strength.....	72,000 psi/496 MPa
Elongation	31%
Machinability	Excellent
Hardness	86 Rb
Impact resistance.....	50 ft-lbs. @ -20°F/-29°C
Current.....	AC or DCEP (DC+)



PROCEDURE

Remove cracked or fatigued metal by grinding or gouging with Arc-Prep #161 electrode. Bevel heavy sections before welding. Preheat according to base metal. Use AC or DCEP current. Use a contact or a minimum arc length with a weave or stringer bead technique. Remove slag between passes. Allow to cool slowly.



APPLICATIONS

- Machinery
- Vessels
- Galvanized steel and sheet metal
- Truck parts
- Agricultural equipment
- Heavy equipment
- Fabrication
- Pipes



INDUSTRIES

- Water treatment
- Trucking
- Municipal vehicle maintenance
- Manufacturing
- Railroad
- Agriculture
- Heavy equipment
- Petrochemical

Code #	Diameter	Amperage
104-3-000B	5/32"	80-150
104-4-000B	1/8"	60-120
104-5-000B	3/32"	45-90