

# LH 111



ELECTRODE WITH SPECIAL COATING FOR WELDING OF CAST IRON

## PROPERTIES

Electrode with stable, smooth and soft arc. HAZ (transition zone) of weld metal is easily machinable.

Minimum penetration and hence very less dilution. No undercuts.

## PROCEDURE

Before starting the weld make sure that the casting is absolutely free from grease, oil, rust, paint or dirt. Use back-step techniques depositing stringer bead not longer than 25 mm. Peen each bead and remove slag thoroughly. Use intermittent welding technique so that the casting does not become too hot.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	80-100
	4.0x350	90-120

## TYPICAL APPLICATIONS

Hot and cold welding on grey cast iron. Repair of machine frames, bearing blocks. Ideal for salvaging foundry castings, gear boxes, machine housing, sugar mill rollers and cast iron dies, Ni hard pumps. For joining cast iron to mild steel.



## SPECIFICATIONS

ALLOY BASIS: Ni



## TECHNICAL DATA

UTS : 30-40 kgf/mm<sup>2</sup>