

# LH 117



NON-MACHINABLE ELECTRODE FOR WELDING CAST IRON

## PROPERTIES

Electrode with good bonding properties even on difficult to weld cast iron. Close colour match between deposit and base material. Non-machinable. Finish by grinding only.

## PROCEDURE

Clean the welding zone. Select the lowest amperage possible. Use short arc and guide the electrode steeply since the electrode gives a spray transfer, helpful for sealing pores on cast iron. If the surface of the welded joint must be machinable, weld the cover passes with either LH 115 or LH 119.

## WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	90-120
	4.0x350	100-140

## TYPICAL APPLICATIONS

Welding or surfacing of cast iron, joining of cast iron to steel, economical electrode particularly for massive parts and large castings, e.g. repair of foundry defects, damaged or cracked castings. Can be successfully used on rusty, corroded and oil soaked parts. For obtaining better machinability, deposit final pass with LH 115 or LH 119.



## SPECIFICATIONS

ALLOY BASIS: Fe, C, Si



## TECHNICAL DATA

UTS : upto 45 kgf/mm<sup>2</sup>