

LH 119



**EXTREMELY CRACK RESISTANT NICKEL
IRON ALLOY ELECTRODE FOR WELDING
CAST IRON**

PROPERTIES

Electrode with excellent welding characteristics. The deposit is machinable and crack-proof. Good bonding on difficult to weld cast iron.

PROCEDURE

Clean the welding zone and check the surface for cracks and defects. Use short arc with low current to deposit stringer bead not exceeding 25 mm. Hot Peen the deposit to reduce residual stresses.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	90-120
	4.0x350	100-130

TYPICAL APPLICATIONS

An unique electrode for cold welding of cast iron without preheat and for joining cast iron to mild steel. Also suitable for surfacing cast iron parts subject to erosion, corrosion and high temperatures. Best suited for repairing intricate cast iron parts, water pump housing, electric motor bodies and covers, machine frames, cylinder blocks and gears. Also ideal for salvaging foundry castings, gear box, differential housing, lathe beads, sugar mill rollers, glass moulds and cast iron dies. Very good for hubs/rollers of VRMs.



SPECIFICATIONS

ALLOY BASIS: Ni, Fe, C



TECHNICAL DATA

UTS : 35-45 kgf/mm²