

# LH-CAST HEAL 113 F

HIGH NICKEL ELECTRODE FOR REPAIRING OF ALL TYPES OF WELDABLE CAST IRON PARTS WITH EXCELLENT MACHINABILITY

## PROPERTIES

Excellent welding alloy for repair of cracks as well as weld build-up of cast iron components. It ensures minimum heat input. No pinholes or cavities are generated. Good for build-up, cladding, crack repair or filling in casting defects.

## TYPICAL APPLICATIONS

- Repair of all types of foundry defects.
- Engine blocks, cast iron gears and pulleys, sliding tables for machine tools, cylinder head, pump casing & impellers, ductile iron pipes
- VRM rollers/hubs

## SPECIAL FEATURES

- Excellent resistant to crack.
- Exhibits excellent machinability
- Suitable for welding of all types of cast iron.
- 'Cold arc' coating offers minimum dilution and penetration.
- Superior for 'out-of-position' welding.
- No pinholes or cavities

## WELDING CURRENT

| CURRENT     | SIZE (MM) | AMPS    |
|-------------|-----------|---------|
| AC / DC (-) | 3.2x350   | 70-100  |
|             | 4.0x350   | 120-150 |

## PROCEDURE

- Clean weld area to remove scale, grease and dirt.
- Drill holes at starting and end of the cracks.
- Remove crack with LH 900 gauging electrode/grinding.
- For re-strained crack application areas preheat upto 200°C.
- Use a short arc at minimum amperage with stringer bead and follow up with skip and staggered weld technique.
- Hot peen weld deposits to avoid local stress build up.
- Remove slag between passes.
- Use buttering layer LH 117 on contaminated and carburized / fatigue surface. Allow to cool slowly.



## TECHNICAL DATA

Tensile Strength: 38 Kgf/mm<sup>2</sup>

# CAST IRON PUMPS IMPELLERS & CASING

REPAIR OF ALL CRACKS

## AREA OF CONCERN

Cast iron being brittle is very much susceptible to cracks and chip offs. Also porosities, cavitation and defects are observed during casting leading to rejection.

## SOLUTION

LH-CAST HEAL 113 F is the most suitable to address all the above concerns. We also offer our specialized service to undertake repair works at site as well as our plants.

## THE COMPANY

Ador Fontech Ltd provides reclamation, fusion, surfacing & spraying solutions for Industrial components. With forty years of experience, comprehensive products & services, we provide optimal & efficient solutions. Our extensive sales & distribution network allows us to cover the most remote locations in India within the shortest possible times. Thereby, making us the preferred partner to improve industrial asset utilisation.

