

LH 115 Electrode for cold welding of cast iron

ALLOY BASIS

Ni

PROPERTIES

Smooth stable arc. Suitable for positional welding. Very little mixing up with base material, consequently the heat affected zone is easily machinable. No under cut.

TECHNICAL DATA

UTS : 38 kgf/mm²

TYPICAL APPLICATIONS

A 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, gears. Also ideal for salvaging foundry castings, gear box and differential housing, lathe beads, sugar mill rollers, glass moulds and cast iron dies.

PROCEDURE

Clean the welding zone and check the surface for cracks and defects. Use a short arc with low current to deposit a stringer bead not exceeding 50 mm. Peen the deposit to reduce residual stresses.

WELDING CURRENT

Current	: AC / DC (-)		
Size (mm)/Length	: 2.5x350	3.2x350	4.0x350
Current (amps)	: 40-75	70-110	90-140



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