

LH 119

Extremely crack resistant nickel iron alloy electrode for welding cast iron

ALLOY BASIS

Ni, Fe

PROPERTIES

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

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 leads, sugar mill rollers, glass moulds and cast iron dies.

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 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)	: 40-90	60-110	80-120



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