

LH 1119



CRACK-RESISTANT NICKEL-IRON ALLOY
ELECTRODE FOR WELDING DIFFERENT
GRADES OF CAST IRONS

PROPERTIES

Electrode with stable and soft arc, regular flow. Minimum penetration and hence very less dilution. Nodular deposit which provides crack-resistivity specially in joining of cast irons to carbon steel. All position weldability. No undercuts. Regular and very fine weld ripples.

PROCEDURE

Gouge out cracks with LH 900. Grind to get even surface on groove faces. Adopt stringer bead and skip welding techniques. Hot peen the deposit. Chip slag between passes. Fill craters. Allow the job to cool slowly to room temperature.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	90-110
	4.0x350	100-130

TYPICAL APPLICATIONS

For all types of ductile cast irons such as: nodular (spheroidal graphite) and malleable as well as grey cast iron, joining of machinable cast irons to carbon steels, overlaying, build up, filling porosity etc. Can be used for heavy and thin sections of cast iron.



SPECIFICATIONS

ALLOY BASIS: Fe, Ni



TECHNICAL DATA

UTS : 36-47 kgf/mm²