

# LH 115



OUTSTANDING ELECTRODE FOR NODULAR AND GREY CAST IRON ELECTRODE FOR COLD WELDING OF CAST IRON

## 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.

## 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	LENGTH	AMPS
AC / DC (+)	2.5x350	50-75
	3.2x350	70-110
	4.0x350	90-140

## 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.



## SPECIFICATIONS

ALLOY BASIS: Ni



## TECHNICAL DATA

Elongation : 30-35%