

# LH 1115

ELECTRODE FOR COLD WELDING OF ALL GRADES OF CAST IRON

## PROPERTIES

Electrode with stable and soft arc, regular flow which can be used for multi position welding. Heat affected zone is easily machinable. Minimum penetration and hence very less dilution. No undercuts. Very fine and even 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	80-100
	4.0x350	100-130

## TYPICAL APPLICATIONS

A versatile, nickel-based electrode for cold welding of all grades of cast iron without preheat. It is recommended for joining carbon steel to all grades of cast iron. Welds withstand severe erosion and corrosion encountered in service. Best suited for repair welding of intricate parts of cast iron, water-pump housing, frame parts, cylinder blocks, gears, etc. Most ideal for salvaging foundry castings, gearboxes, sugar mill rollers, glass moulds, cast body of crushers etc.



## SPECIFICATIONS

ALLOY BASIS: Ni



## TECHNICAL DATA

UTS : 32-38 kgf/mm<sup>2</sup>