

LH 119S

CRACK RESISTANT NICKEL-IRON
ELECTRODE FOR WELDING ALL TYPES OF
MACHINABLE LOW ALLOY AND
UNALLOYED CAST IRON

PROPERTIES

The electrode burns with quiet arc and has excellent weldability on grey cast iron. The weld deposits are easily machinable and are free from cracks and porosity. Weld deposit should be lightly peened to reduce thermal stresses.

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 25 mm. Hot Peen the deposit to reduce residual stresses.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	90-120
	4.0x350	100-130

TYPICAL APPLICATIONS

Cold welding of all types of unalloyed and low alloy cast irons, malleable cast iron, correcting machining error, joining of machinable grey cast iron to carbon steel, welding of grey cast iron. Foundry castings, machine parts made from grey cast irons, etc.



SPECIFICATIONS

ALLOY BASIS: C, Ni, Fe



TECHNICAL DATA

UTS : 35-45 kgf/mm²