

# LEADER 1119

## Applications

Hot and cold Welding of Cast iron part of Grey Cast Iron , nodular graphite iron , melleable iron subject to heavy wear. Joining of Cast metarial with steel. The electrode is most suitable for the surfacing of the above materials. Casting machinable parts , bearing blocks, frames, foundry casting etc.

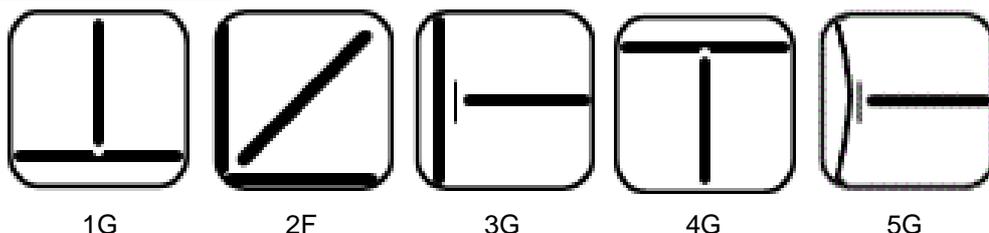
## Characteristics on Usage

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

## Notes On Usage

- ✍ Sufficient amount of the casting skin should be removed.
- ✍ Depending on the job thickness a U weld or double U weld or should be made, use shortest possible arc length.
- ✍ The pass width should not be more then twice the diameter of the core wire.
- ✍ Deslag every weld bead and peen the weld metal carefully

## Welding Positions



## Mechanical Properties Of Weld Metal

U.T.S. (N/mm <sup>2</sup> )	HARDNESS ON III rd LAYER
35 - 45	150 - 190 BHN

## Packing and Welding Current

SIZE ( mm )	KG PER PACKET	KG PER CARTON	In Amps
2.50 X 350	2	10	40 - 90
3.15 X 350	2	10	80 - 120
4.00 X 350	2	10	100 - 130
5.00 X 350	2	10	140 - 170