

GRICAST LH



CLASSIFICATION : AWS /SFA 5.15 : Est

DESCRIPTION :

An extruded , medium heavy coated cast iron electrode. Weldable in all positions except vertical down. Arc striking and re-striking properties are very good. Arc is soft & stable . Slag is easy to remove. Low spatters. Weld metal is not machinable. Bead appearance is fine with uniform ripples.

TYPICAL APPLICATION :

Due to the special coating, welding of cast iron containing high percentages of phosphorous and Sulphur is possible. Applicable for joining and repairing of cast iron as well as for joining cast iron to mild steel. Also for welding the steel of unknown composition.

WELDING INSTRUCTIONS :

Pre-heating of the work-piece is required for heavy sections.

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS DC(+)	PACKING PER BOX
2.50	350	60-85	2KgX6=12Kg
3.15	450	110-130	2KgX6=12Kg
4.00	450	130-180	2KgX6=12Kg
5.00	450	180-220	2KgX6=12Kg
6.30	450	220-280	2KgX6=12Kg

