

GRICAST LH

IDENTIFICATION

Gricast LH, Est

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.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Fe
0.15 max	0.60 max	0.15 max	0.04 max	0.04 max	Rem.

TYPICAL APPLICATIONS

- 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.

PACKING PARAMETERS

Size (mm)	Length (mm)	AMPS DC (+)	Packing / Box (kg)
2.5	350	60 - 85	2 x 5 = 10
3.15 / 3.20	350	110 - 130	2 x 5 = 10
4	350	130 - 180	2 x 5 = 10
5	350	180 - 220	2 x 5 = 10
6.3	350	220 - 280	2 x 5 = 10