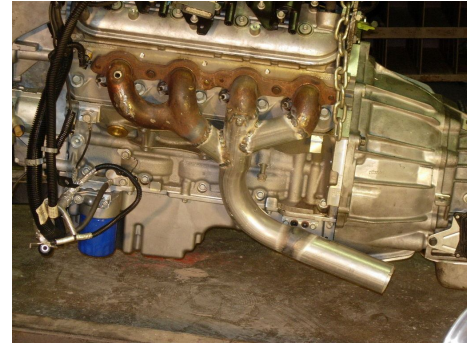




# Lehami 7720

**Nickel-Free Cast Iron Problem-Solver:  
Seals in porosity generating contaminants  
prior to weld-finishing with nickel-based  
cast iron alloys.**



## **SPECIAL FEATURES**

- Easily clads heat oxidized and oil impregnated castings
- Perfect color match to cast iron
- Non-conductive flux coating
- "Quick Freeze Action" means deposits solidify before defects and porosity have a chance to form.

## **APPLICATIONS**

LEHAMI 7720 seals off contaminants on greasy, dirty and burned cast iron so that sound welding can proceed. Use LEHAMI 7720 for: furnace gates, ornamental iron fabrication, oil-saturated cast iron, foundry casting repairs, steel-to-cast iron welding, exhaust manifolds.

## **AVAILABLE SIZES**

<i>INCHES</i>	<i>METRIC</i>	<i>GAUGE</i>	<i>RECOMMENDED AMPERAGE</i>
3/32"	2.5 mm	12	45 - 85
1/8"	3.20 mm	10	70 - 125
5/32"	4.0 mm	8	95 - 150

**RECOMMENDED CURRENT:** DC Reverse polarity (Electrode +) or AC

**WELDING POSITIONS:** Flat, Horizontal, Vertical Up, Vertical Down, Overhead

## **WELDING TECHNIQUES**

Use stringer or moderate weave technique. When cladding, cover the entire base surface prior to finish welding.

**TYPICAL MECHANICAL PROPERTIES**

**Undiluted Weld Metal**

**Maximum Value Up to:**

Tensile Strength	62,000 psi (440 N / mm <sup>2</sup> )
Yield Strength	50,000 psi (360 N / mm <sup>2</sup> )
Elongation	20 %
Hardness	Rockwell C 39, Brinell 380

**DEPOSITION RATES**

<i>Diameter</i>	<i>Length</i>	<i>Weldmetal / Electrode</i>	<i>Electrodes per lb (kg) of Weldmetal</i>	<i>Arc Time of Deposition in Minutes per lb (kg) of Weldmetal</i>	<i>Amperage Setting</i>	<i>Recovery Rate</i>
3/32" (2.5 mm)	14" (350 mm)	0.30 oz (8 g)	53 (117)	36 (79)	70	100%
1/8" (3.2 mm)	14" (350 mm)	0.62 oz (17 g)	26 (57)	25 (55)	100	100%
5/32" (4.0 mm)	14" (350 mm)	1.0oz (28 g)	16 (35)	20 (44)	135	100%

**WELD METAL ANALYSIS (Typical Weight,%)**

C	Fe	Mn	P	S	Si
0.12	bal	0.58	0.03	0.03	0.02

<b>INTERNATIONAL SPECIFICATIONS</b>	<b>AWS/ASME A5.15: ESt</b>	<b>DIN 8573: E Fe-1</b>
	<b>ISO 1071: E Fe</b>	