



# WELDING AND FLAME CUTTING OF LIP PLATES AND V-TIPS

## FILLER MATERIALS

Low-hydrogen, alkaline electrode OK 48.00, or  
MIG/ MAG-method, OK Autrod 12.51.  
Weld HD<10ml/100g.

## PREHEATING

100–150 °C

## WORKING TEMPERATURE

150–200 °C welded complete. Lip plates must be welded at  
the same temperature until complete.

## WELDING WORK

V or K welding groove, groove angle less than 45°, root gap  
2–4 mm, root face 3–5 mm. Finish the completed groove by  
grinding. Tack symmetrically and make the groove strong at  
the centre of the plate. Welding energy 1,5–3,0 kJ/mm.

Proceed in the welding from the centre towards the edges in  
order to give the lip plate the right shape, i.e. curved down-  
ward at the centre 1cm/m. Remember that the lip plate warps  
during welding. Warping should be as unrestricted as possible  
so take warping into consideration in the initial settings.



Completely fill the seam from inside the bucket, turn the  
bucket and open the root.

We recommend the use of starting and ending blocks. Open  
the root, avoid carbon-arc gouging but if you cannot, grind  
away all of its traces. Cooling can be slowed down and con-  
trolled e.g. by covering the piece with mineral wool. This is  
particularly important if the workshop is cool. Finally, grind all  
edges and angles.

## FLAME CUTTING

The same preheating need and working temperatures as in  
welding. You can slow down cooling by covering the piece  
with mineral wool. Do not speed up cooling. Remember that  
you are dealing with a hardening, rigid, strong material that  
can be welded and flame cut successfully by following the  
above instructions.