



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 metals 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 downward 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 controlled 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.

FURTHER INFORMATION

Miilux general welding instructions.
Miilux Oy's customer service
Tel. +358 8 2113 500 and
customer.service@miilux.fi

