ARMORITE WELDING DETAILS

RECOMMENDED WELDING PROCEDURES

READ ALL CUTTING PROCEDURES COMPLETELY!

We recommend you always use a soft-face hammer and ANSI-approved (Z87.1) eye protection during cutting and bending procedures.

1. Ensure that the surface to which the Armorite will be attached is as flat as possible and the area to be welded is clean.

2. Clamp and tack weld Armorite into position.

3. Stitch weld, laying 2" (51mm) max length on each run, alternating ends or similar to minimize heat input. **Do not** deposit weld within **2mm** from the joint line between white iron and steel backing plate **(Fig.1)**.

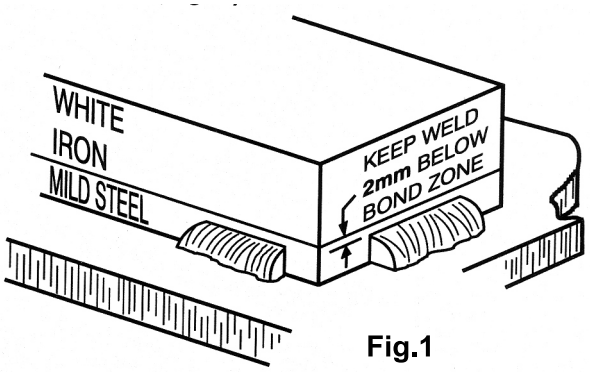

Fig.1

4. **DO NOT WELD CONTINUOUSLY** - Continuous welding may cause warpage, delamination and cracking

5. If a complete peripheral weld is required, use stitch weld method as per step 3.

6. WELDING RODS

ASGCO RECOMMENDS LOW HYDROGEN WELD RODS OR GAS COVERED CORED WIRE.

Gas shielded solid MIG wire - 3/64" (1.2mm) dia. max.
Flux cored wire - 1/16" (1.6 mm) dia. max.
Low hydrogen electrode - 1/8" (3.25 mm) dia. max.

WELDING PROCEDURE OVERVIEW

1. **READ PROCEDURE COMPLETELY**
2. TACK WELD INTO POSITION
3. STITCH WELD WITH 2" (51mm) MAX. LENGTH ON EACH RUN
4. MAINTAIN 2MM GAP BETWEEN WELD AND JOINT LINE
5. COMPLETE PERIPHERAL WELD IF REQUIRED

CAUTION! TOO MUCH HEAT INPUT MAY CAUSE CRACKING AND SEPERATION