



**italricambi S.p.A.**



# WELDING INSTRUCTIONS

## **-GENERAL INSTRUCTIONS**

### ***Cleaning and preliminary preparation.***

First, clean the surfaces to weld. The target is to remove paint, greases, oxides and other elements which can produce blowholes in the welding stage or other problems.

### ***Preheating.***

Its principal target is to prevent cracks. To avoid them, preheat and keep the area to be weld between 150-200°C, special attention recommended in case of profiles with a higher than 25mm thickness or at a lower than +10°C temperature.

Preheating during welding does favour the emission of hydrogen from steel and, therefore, it considerably reduces the risk of cracking.

### ***Covered electrode procedure.***

If you use covered electrodes, we recommend to use basic covered electrodes with a low-hydrogen content.