

## **WELD REPAIR PROCEDURE:**

The following is recommended weld repair procedure for Bromalloy 152 glass containers moulds:

Pre-heat at 150-200°C

Post weld slowly cool parts back to 150-200°C prior to machining

Recommend weld repair materials:

COLMONOY® 225 (or equivalent) weld power

ADDIFIX 890 TIG Weld Wire (or equivalent)

CRONATIG 3880T TIG Weld wire (or equivalent)

### **CAUTION:**

*Ventilation Requirements:* Local Exhaust and General Ventilation

*Local Exhaust:* Use Local Exhaust During Welding, Cutting, or Milling to Avoid Exposure to Metal Oxide Fumes

*Mechanical:* Good General Ventilation During Handling of Solid Material Should be Used to Control Dust Generated

*Protective Gloves:* Gloves Recommended During Handling to Prevent Cuts and Abrasions