ABSTRACT

METHOD FOR REPAIRING WORN VALVE SPINDLES

The invention relates to a method for repairing worn valve spindles comprising a valve body (13) consisting of an iron-base alloy and sheath sections forming a sheath body (9) in the region of the valve head (1) consisting of a Ni-base alloy, at least in the region of the head bottom (7) and the head circumference (8), and a wear-resistant coating in the seat region (4). The sheath sections are turned off to an initial shape (11) of the valve head (1), until a defined minimum dimension of the valve head (1) with a metallic blank surface is reached. An austenitic steel alloy is welded onto the initial shape (11), forming a first head shape, the first head shape is turned off until a defined inner shape (10) of the valve head (1) is obtained, a Ni-base alloy is welded to the inner shape (10) in order to form a second head shape, and the second head shape is turned off until a defined end shape (12) of the valve head (1) is obtained, such that the thickness of the sheath body is at least 2.5 mm.

Fig. 1