



Superior Moisture Resistance  
and  
Radiographic Quality

**LOMELT**

**LOMELT 102-S**

ac/dc\*

**PRINCIPAL APPLICATIONS:**

Repair of broken Structural Steel Components, Casting Defects, Pressure Vessels, Flanges, Crane Jibs, Automobile Chassis, Frames, Heavy Equipment maintenance, Steels with Sulphur & Phosphorus and also for buffer layer before hard surfacing.

**SPECIAL FEATURES:**

- Gives radiographic quality welds.
- Ideal for restrained and oil soaked parts.
- Excellent impact resistance and ductility.
- High strength and crack free deposits.

**RECOMMENDATIONS:**

For low alloy high tensile steels, cast steels, cast irons, problem steels having sulphur and other alloying elements added to base metal for better machinability. These alloying elements which can cause porosity/hidden defects are purged with the electrode arc action from the molten pool. Most suitable where toughness and weld reliability are important.

**PROCEDURE:**

Clean weld area of any surface contamination. Use a short arc for horizontal fillets. Contact technique may be used. For vertical joints, use rapid weaving and start welding from bottom. For welding heavy sections in cast steel, preheating may prove beneficial.

**TENSILE STRENGTH** : 58 kgf/mm<sup>2</sup> (Typ.)

**ELONGATION** : 27% (Typ.)

**RECOMMENDED AMPERAGE:**

Size	Range
2.50 mm	60-80 Amps
3.15 mm	90-120 Amps
4.00 mm	120-160 Amps
5.00 mm	150-200 Amps



**MODI ARC ELECTRODES CO.**

Modinagar - 201 204 (U.P.)

Fax : 01232 - 242147

Phone : (01232) 325700, 325925, 243912

E-mail : modiarc@ndb.vsnl.net.in

Web Site : [www.modielectrodes.com](http://www.modielectrodes.com)