



Superior Moisture Resistance
and
Radiographic Quality

LOMELT

LOMELT 102

ac/dc*

PRINCIPAL APPLICATIONS:

Pressure Vessels, Heavy Equipment Maintenance, Flanges, Crane Jibs, Automative frames, Crane booms, Automobile chassis, Steels with High Sulphur & Phosphorus.

SPECIAL FEATURES:

- Hydrogen controlled, low alloy, high tensile steel electrode.
- 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, 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. 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/mm² (Typ.)

ELONGATION : 28% (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



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