



Low Heat Input  
and  
Corrosion Resistance

**LOMELT**

**LOMELT 201**

ac/dc\*

**PRINCIPAL APPLICATIONS:**

Oil refineries, Chemical industry, Breweries, Dairy equipments, Kitchen equipments, Food processing equipments.

**SPECIAL FEATURES:**

- Stabilized 19/9.5 Cr/Ni/Cb electrode.
- Resists heat, corrosion and carbide precipitation.
- Weld metal is of radiographic quality.

**RECOMMENDATIONS:**

A low heat input electrode for welding of stainless steel types AISI 304, 304L, 321 & 347. Good for welding of parts used in severe corrosive conditions. Specially formulated flux coating permits welding at low amperage in all positions.

**PROCEDURE:**

Clean weld area of oil, grease and dirt. Bevel thicknesses above 10 gauge to 60° Vee. Fit ups should be accurate for long seams. Use of proper holding device or suitable clamping will minimize warping. Tack at short intervals. Maintaining short arc, use skip welding technique. Avoid weaving and remove slag between passes.

**TENSILE STRENGTH** : 60 kgf/mm<sup>2</sup> (Typ.)

**ELONGATION** : 35% (Typ.)

**RECOMMENDED AMPERAGE:**

Size	Range
2.50 mm	50-70 Amps
3.15 mm	70-90 Amps
4.00 mm	100-130 Amps
5.00 mm	130-160 Amps



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