



Excellent Weldability
and
Ultimate Strength

LOMELT

LOMELT 205

ac/dc*

PRINCIPAL APPLICATIONS:

Tools, Dies, Gears, Pinions, Springs, Shafts, Dissimilar steels, Leaf springs, Wear plates, Gear boxes & Earth moving equipments.

SPECIAL FEATURES:

- High alloy, high strength electrode.
- Deposits are very tough for superior crack resistance.
- Optimum resistance to friction, heat, corrosion and impact.
- A versatile electrode; can be used on all steels including unidentified steels.
- Low amperage, extremely low spatter, easy strike-restrike, easy slag removal.
- Use for speed, economy, reliability and high quality welds.

RECOMMENDATIONS:

A versatile electrode for welding most types of steels. The deposit of Lomelt 205 is a super alloy austenoferritic steel with upto 30% ferrite content, very high tensile strength and lends itself admirably to the welding of dissimilar and problem steels. Lomelt 205 is recommended for high strength joints in high carbon steels, alloy steels, austenitic manganese steels, die steel, tool steel and welding dissimilar grades of stainless and heat resisting steels. Also recommended for use as buffer layer on difficult steels prior to hard facing.

PROCEDURE:

Clean weld area of grease, oil or any surface contamination. Use ac or dc reverse polarity. Hold short arc. Restrict the weaving to 2x electrode diameter. Intermittent welds may be necessary for welding high alloy steels. Burn-off rate is rapid permitting speedier welding. Peen to relieve stresses.

TENSILE STRENGTH : 85 kgf/mm² (Typ.)

ELONGATION : 25% (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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