



Very High Deposition Rate  
and  
Impact Resistance

**LOMELT**

**LOMELT 207**

ac/dc\*

**PRINCIPAL APPLICATIONS:**

Excavator parts, Dredger teeth, Rail surfaces, Joining austenitic stainless steel to hardenable steels.

**SPECIAL FEATURES:**

- Very high deposition rate.
- Excellent work hardening property with good impact resistance.
- High crack resistance.

**RECOMMENDATIONS:**

For weld repair and cladding worn parts of 13% Mn steel. For composite S.S. cladding on carbon and low alloy steels. Also recommended for joining austenitic manganese steels to carbon steels or stainless steels.

**PROCEDURE:**

Clean weld area of any surface contamination. Use of Lomelt 602 is recommended to remove fatigued or damaged metal. Preheat is not recommended. Maintain a short to medium arc length. Restrict the bead length to about 12 cms at a time. Care should be taken to ensure that interpass temperature is kept below 150° C. Skip welding is advised for large parts. Peening is recommended on hot welds. Cool slowly.

**HARDNESS** (As deposited) : 180 BHN (Typ.)  
(Work Hardened) : upto 450 BHN

**RECOMMENDED AMPERAGE:**

Size	Range
3.15 mm	100-130 Amps
4.00 mm	140-180 Amps
5.00 mm	160-200 Amps



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