



Excellent Resistance
to
Wear Due to Heavy Impact

LOMELT

LOMELT 209

ac/dc*

PRINCIPAL APPLICATIONS:

Welding of Crusher Roller, Hammers, Impact Bars, Gyratory Cones, Bucket Teeth, Rail Road Points and Crossings.

SPECIAL FEATURES:

- Tough work hardening deposits.
- High crack resistance.
- Good wear resistance under heavy impact conditions.

RECOMMENDATIONS:

For reclamation of rail road points and crossings, hammers and crusher rollers. Ideal for welding of high austenitic manganese steels. Specially recommended for parts requiring good wear resistance under heavy impact conditions.

PROCEDURE:

Clean weld area of any surface contamination. Use Lomelt 602 to remove damaged metal. Do not preheat manganese steel. Use short to medium arc and stringer bead technique. Keep interpass temperature below 150° C. To restrict heat build up, skip or back step sequence of welding should be used. Peen to relieve stresses. Allow slow cooling.

HARDNESS (As deposited) : 220 BHN (Typ.)
(Work Hardened) : upto 500 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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