



High Strength
and
Crack Free Deposit

LOMELT 210

LOMELT

ac/dc*

PRINCIPAL APPLICATIONS:

Dissimilar Steels, Stainless Steels, Tool Steels, Cast Steels, Base layer before hardfacing.

SPECIAL FEATURES:

- Austo-ferrite structure is obtained in weld metal matrix.
- Excellent resistance to friction, heat and corrosion.
- Gives tough crack free weld deposits.
- Versatile electrode for all position welding.

RECOMMENDATIONS:

A versatile electrode for welding of almost all steels, of even unknown composition. The electrode is recommended for achieving high strength and crack free deposit with controlled grain structure in high carbon steels etc. Also recommended for use as buffer layer on difficult to weld steels prior to hardfacing.

PROCEDURE:

Weld surface has to be free from impregnated oil, grease and lubricants. Hold short arc. Weld intermittently for high alloy steels. For relieving locked-up stress, peening is necessary. Each pass should be cooled before chipping.

TENSILE STRENGTH : 85 kgf/mm² (Typ.)

ELONGATION : 22% (Typ.)

RECOMMENDED AMPERAGE:

Size	Range
2.50 mm	50-70 Amps
3.15 mm	70-90 Amps
4.00 mm	90-120 Amps
5.00 mm	120-150 Amps



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