



Highly Machinable  
and  
Low Heat Input

**LOMELT**

**LOMELT 403**

ac/dc\*

**PRINCIPAL APPLICATIONS:**

Engine blocks (Water jackets), Pump housing, Cylinder blocks, Cast iron gears and pulleys, Machine beds, Glass moulds.

**SPECIAL FEATURES:**

- Low heat input and all position electrode.
- Excellent weldability and machinability.
- Suitable for variety of cast irons.

**RECOMMENDATIONS:**

For thin walled grey cast iron and building up missing sections in all positions. Best suited for cladding, repairing cracks and joining of C.I. to other metals. Exceptionally good for vertical and overhead welding.

**PROCEDURE:**

Clean the weld area of any grease etc. Use Lomelt 602 to chamfer out the crack. Preheat of 200°C is recommended to obtain maximum machinability. Use base layer of Lomelt 405 on oil soaked cast iron. Adjust minimum amperage and use short to medium arc. Weld deposit can be made using stringer or weaving technique. Skip weld technique to be adopted to avoid excessive heat build up. Peen to relieve stresses. Remove slag between passes. Allow slow cooling.

**TENSILE STRENGTH** : 35-45 kgf/mm<sup>2</sup>

**HARDNESS** (As deposited) : 180 BHN (Max.)

**RECOMMENDED AMPERAGE:**

Size	Range
2.50 mm	45-70 Amps
3.15 mm	70-110 Amps
4.00 mm	90-120 Amps
5.00 mm	130-160 Amps



**MODI ARC ELECTRODES CO.**

Modinagar - 201 204 (U.P.)

Fax : 01232 - 242147

Phone : (01232) 325700, 325925, 243912

E-mail : modiarc@ndb.vsnl.net.in

Web Site : [www.modielectrodes.com](http://www.modielectrodes.com)