



Best Colour Match
and
High Crack Resistance

LOMELT

ac/dc*

LOMELT 404

PRINCIPAL APPLICATIONS:

Pump rotors, Pump housing, Compressors, Valves, Gear boxes.

SPECIAL FEATURES:

- Controlled penetration.
- High weld metal density.
- Greater ease of application.
- Best colour match.

RECOMMENDATIONS:

For welding of grey, malleable and nodular cast irons. Cast iron with unknown composition can also be welded. Use where maximum machinability is required. Specially formulated flux coating controls penetration and prevents excessive base metal dilution.

PROCEDURE:

Gouge out cracks with Lomelt 602. Clean weld area. No preheating of the job is necessary but preheat upto 100°C gives best results and machinability. Use base layer of Lomelt 405 on oil soaked cast iron. Maintain a short to medium arc at lowest amperage. Deposit short stringer beads of 30 to 35 mm length. Back whip the craters. Light peening is recommended to remove stresses. Remove slag between passes.

TENSILE STRENGTH : 35-45 kgf/mm²

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

RECOMMENDED AMPERAGE:

Size	Range
2.50 mm	60-90 Amps
3.15 mm	90-120 Amps
4.00 mm	120-140 Amps
5.00 mm	140-180 Amps



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