



Smooth, Spatterfree
and
Machinable Deposit

LOMELT

LOMELT 502 (AC)

ac/dc*

PRINCIPAL APPLICATIONS:

Packing glands, Sleeves, Castings, Pump casings, Impellers, Marine components & Gear teeth.

SPECIAL FEATURES:

- Exceptional Weldability.
- Versatile electrode for joining and over-laying of steels, cast irons and bronze etc.
- Porosity free, dense deposits which are easily machinable.
- Colour matching with bronze.

RECOMMENDATIONS:

An exceptional bronze alloy electrode having excellent weldability. The force of the arc is strong and stable. The deposits after smooth finish have a low coefficient of friction. Deposits resist salt water and steam corrosion.

PROCEDURE:

Clean weld area of any contamination. Bevel the edges. Heavy sections should be preheated to 150°C-300°C. Maintain short arc at lowest amperage and deposit stringer beads. Remove slag between passes. Do not allow the job to get over heated.

TENSILE STRENGTH : 30 kgf/mm² (Typ.)

RECOMMENDED AMPERAGE:

Size	Range
2.50 mm	40-70 Amps
3.15 mm	70-100 Amps
4.00 mm	100-140 Amps
5.00 mm	140-180 Amps



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