



Excellent Deposit Appearance  
and  
Self Releasing Slag

**LOMELT**

**LOMELT 101**

ac/dc\*

**PRINCIPAL APPLICATIONS:**

Ducts, Bus Bodies, Tanks, Pipelines, Furniture, Chassis, Air-conditioning units, Machine guards

**SPECIAL FEATURES:**

- Instantaneous strike and restrike.
- All position touch type welding.
- Unmatched uniformity of weld bead.
- Minimum distortion and warpage due to minimum heat input.
- Weld bead is of radiographic quality.

**RECOMMENDATIONS:**

A versatile all position electrode for low carbon steels. Especially recommended for thin gauge sheets and plates, where warpage distortion and stresses are to be kept minimum and burn through eliminated.

**PROCEDURE:**

Clean weld area of any surface contamination. For shallow penetration use dc straight polarity and for deep penetration use dc reverse polarity. Longer sections should be tack welded to maintain alignment. Hold electrode at about 70° to the base in the direction of travel. Arc gap should be minimum where distortion and position of welding are important factors.

**TENSILE STRENGTH** : 50 kgf/mm<sup>2</sup> (Typ.)

**ELONGATION** : 26% (Typ.)

**RECOMMENDED AMPERAGE:**

Size	Range
2.00 mm	35-55 Amps
2.50 mm	60-80 Amps
3.15 mm	80-110 Amps
4.00 mm	110-160 Amps
5.00 mm	140-200 Amps



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