



Excellent Machinability  
and  
Crack Resistance

**LOMELT**

**LOMELT 213**

ac/dc\*

**PRINCIPAL APPLICATIONS:**

Joining of Wear Plates, Shafts, Leaf Springs, Dissimilar Steels and Base Layer before Hardfacing.

**SPECIAL FEATURES:**

- High strength weld deposit with excellent machinability and superior crack resistance.
- A universal & versatile electrode; can be used on variety of steels.
- Extremely low spatter, easy strike & restrike at low amperage.

**RECOMMENDATIONS:**

A versatile low heat input electrode, which confirms to IS5206/83, E29.9, can be used for welding of all similar and dissimilar steels. Recommended for crack free high strength joints in high carbon steels, high alloy steels, die steels and tool steels etc.

**PROCEDURE:**

Clean weld area of grease, oil or any surface contamination. Grind/ gouge out fatigued metal & cracks. Preheat heavy sections, high carbon steels and certain high alloy tool steels. Use ac or dc+. Use short arc and stringer bead technique. Burn-off rate is rapid permitting speedier welding. Peen to relieve stresses.

**TENSILE STRENGTH** : 85 kgf/mm<sup>2</sup> (Typ.)

**ELONGATION** : 25% (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



**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)