



Resistance
to
Abrasion and Heat

LOMELT 302

LOMELT

ac/dc*

PRINCIPAL APPLICATIONS:

Forging dies, Cold punch dies, Plough shares, Brakeshoes, Wobblers, Excavating equipments.

SPECIAL FEATURES:

- Tough weld metal with easy slag removal.
- Easy arc strike and re-strike.
- All position welding and multipass buildup.

RECOMMENDATIONS:

For overlaying on parts subjected to abrasive wear and impact. Can be used on steels, manganese steels and malleable iron. Especially recommended for multipass buildup. Electrode can be used in all position.

PROCEDURE:

Clean weld area of grease, oil and dirt. Use Lomelt 602 for removing damaged/fatigued metal. Preheating of heavy sections to about 230° C is recommended for best results. Stringer or weaving technique may be used holding a short to medium arc. Long deposits can be made without danger of cracking. Do not allow excessive heat buildup. Remove slag between passes and allow to cool.

HARDNESS (As deposited) : 350-400 BHN

RECOMMENDED AMPERAGE:

Size	Range
3.15 mm	90-110 Amps
4.00 mm	120-150 Amps
5.00 mm	150-190 Amps



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