



Toughness  
and  
Wear Resistance

**LOMELT**

**LOMELT 303 (S)**

ac/dc\*

**PRINCIPAL APPLICATIONS:**

Shovels, Plough shares, Excavating equipments, Scrappers, Buckets, Impellers, Jaw crushers, Tie Temping Tools.

**SPECIAL FEATURES:**

- Resists wear due to abrasion.
- Tough, dense and porosity free deposits in all positions.
- Multi-pass build up possible.

**RECOMMENDATIONS:**

For protective coatings on parts subjected to abrasive wear and some impact. Can be used on carbon steels, manganese steels and malleable iron. Can be used on both new or worn out parts. Recommended for multi-pass buildup in all positions. Good resistance to low stress scratching and high stress gauging.

**PROCEDURE:**

Clean weld area and sear away fatigued metal using Lomelt 602. Preheat heavy sections to 200°C - 250°C. Use stringer or weaving technique keeping short to medium arc length. Long deposits and multi-pass buildups can be made without any chance of cracking. Do not allow base metal to be overheated. Remove slag between passes and allow to cool.

**HARDNESS** (As deposited) : 560-660 BHN

**RECOMMENDED AMPERAGE:**

Size	Range
3.15 mm	90-120 Amps
4.00 mm	120-150 Amps
5.00 mm	150-200 Amps



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