



Excellent Weldability
and
Low Heat Input

LOMELT 501

LOMELT

ac/dc*

PRINCIPAL APPLICATIONS:

Bearing surfaces, Bus bar, Valves, Moulds, Ship propellers, Impeller blades, Casting salvage, Dissimilar metals.

SPECIAL FEATURES:

- Low Heat Input.
- For use on copper alloys, steels and C.I.
- Porosity free, dense deposit fully machinable.
- Good resistance to wear due to corrosion.

RECOMMENDATIONS:

For excellent colour match to bronze and for smooth, spatterfree and dense machinable deposit. Excellent for welding of steels and cast irons to copper alloys. Also for repairing breaks and cracks in copper alloy castings, building up missing sections.

PROCEDURE:

Clean the weld area of any surface contamination. Preheat is not required for welding of thin sections. However, heavy sections should be heated to 200°C. Brass requires a preheat upto 300°C. Maintaining a close arc, use stringer beads or slight weaving technique. Remove slag by light chipping and brushing after the part is cooled. Do not allow the job to get over heated.

TENSILE STRENGTH : 28 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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