



Excellent Resistance
to
Thermal Shock

LOMELT 704

LOMELT

ac/dc*

PRINCIPAL APPLICATIONS:

Heat treatment equipments such as Retorts, Racks, Guide shoes, Mantle bars, Tongs, Rotary kiln tyres, joining of dissimilar steels, Air tube (inside kiln), Slag Runners, Hot Air Tube (Spong iron Plant).

SPECIAL FEATURES:

- Excellent resistance to high heat corrosion.
- Tough and porosity free deposits.
- Excellent weldability without overheating of electrodes.

RECOMMENDATIONS:

Weld deposit is suitable for steels including heat treatable types, difficult to weld and of any other unknown composition. Ideal for nickel alloys and their dissimilar combinations. Weldmetal can withstand stresses developed due to thermal shock.

PROCEDURE:

Clean the weld area of any surface contamination. Sear away fatigued metal using Lomelt 602. Bevels are to be prepared for heavy sections. Preheating is recommended only for materials prone to cold cracking. Use stringer beads with short arc and lower range of current. Backwhip all creaters & clean between the passes. Peen the Weld metal and allow to cool at slow rate.

TENSILE STRENGTH : 62 kgf/mm² (Typ.)

RECOMMENDED AMPERAGE:

Size	Range
2.50 mm	50-80 Amps
3.15 mm	80-120 Amps
4.00 mm	120-150 Amps
5.00 mm	140-170 Amps



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