



LOTHERME



LoTherme - 210 R

A medium coated electrode for low heat input welding of mild steel with minimal distortion.

Characteristics :

LoTherme-210R produces excellent weld finish. It operates equally well in all conventional positions. Finely rippled weld beads, soft and steady arc radiographic quality weld and self-detachable slags are a few among many pleasant features associated with LoTherme-210R.

Applications :

LoTherme-210R used for fabrication and repairing of Buckles, Gear cases, Protector tubs, Door patches, Side panels, End wall patches etc. of rolling stocks and locomotives.

Mechanical Properties Of All Weld Metal :

Property	UTS (MPa)	YS (MPa)	% El (L=5d)	%RA	CVN Impact Strength at 0°C (Joules)
Range	410 Min	330 Min	26 Min	50 Min	47 Min
Typical	480	400	27	60	54

Coating Factor: Medium (1.36 to 1.50)

Welding Technique:

Keep the electrode dry. Clean the weld area free of any surface contamination. Use low current and short arc technique.

Current & Packing Data: AC / DC(±)

Size (mm)	5 x 350	4 x 350	3.15 x 350	2.5 x 350
Dia x Length				
Current Range (Amps)	150-200	120-150	90-120	60-90

APPROVAL: RDSO: IRS M28 Class E-1