LoTherme

Estd. 1966 D&H sécheron Complete Welding Support

LoTherme - 351

Low heat input basic coated type high-yield hydrogen controlled electrode.

Characteristics :

- Steady, smooth arc, which is easy to strike and re-strike.
- Extremely low spatter, excellent slag detachability and finely rippled weld beads.
- Radiographic quality welds having excellent cracking resistance.
- Weld metal of excellent toughness to withstand heavy dynamic loading and impact.

Applications :

LoTherme 351 is ideally suited for welding carbon steels used in the construction of machinery and equipment subjected to heavy dynamic load, impact and severe service conditions. Some of the typical applications include: Heavy structures subjected to dynamic loading and impact, Highly restrained joints, Rail coaches, Wagons, Ships, Girders for columns, bridges, Blast furnace shells, Rotary kiln shells, building machinery, Earth moving machinery, Boilers, Pressure vessels.

Typical Mechanical Properties Of All Weld Metal :

Ultimate Tensile Strength : 520 MPa

Elongation (L=4d) : 28 %

Welding Technique :

Re-dry the electrodes at 250°C for one hour before use. Clean the weld area completely free of oil, grease, paint, rust or any other foreign matter. For welding heavy sections in cast steel, preheating of the part may prove beneficial. Use short arc.

Current Conditions : DC (+)/AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	170-220	130-160	90-120	60-90