



LoTHERME



LoTherme - 355

An extra low hydrogen low heat input electrode depositing a low alloy steel weld metal. Extra high strength facilitates welding of critical jobs.

Characteristics :

LoTherme-355 is an extra low hydrogen low heat input electrode depositing a low alloy steel, high strength weld metal ideal for maintenance and repair welding of Cr - Ni - Mo high strength low alloy steels, case hardened steels, heat-treated steels, etc. The extra low hydrogen helps in preventing cold cracks.

Applications :

Ideal for maintenance and repair welding of high strength steels, case hardened steels, heat-treated steels, etc. Typical applications include welding of rolls, shafts, gear wheels, etc.

Typical Mechanical Properties Of All Weld Metal :

Ultimate Tensile Strength : 765 MPa

Elongation (L=4d) : 20 %

Welding Technique :

Re-dry the electrodes at 350°C for 2 hours. Clean the weld area free of all contaminants. In case of the case hardened materials, the case depth should be removed before welding. Depending on the base material, a suitable procedure should be evolved for reclamation.

Current Conditions : DC (+)/AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	150-170	110-140	80-120	50-70
(Amps)				