



LoTHERME



LoTherme - 357

Low heat input electrode for withstanding moderate thermal shocks, on carbon steel applications only.

Characteristics :

LoTherme-357, is a special type electrode, operates equally well in all conventional positions. Smooth and soft arc, which is easy to strike and restrike. Finely rippled smooth weld beads. Crack free RADIOGRAPHIC welds are the special features of LoTherme-357.

Applications :

LoTherme-357 is a versatile low heat input electrode. Ideally suited for welding 0.5Cr-0.5Mo, 1Cr-0.5Mo and 1.25Cr-0.5Mo steels. The weld deposit gives good tensile strength.

Typical Mechanical Properties Of All Weld Metal :

Ultimate Tensile Strength : 590 MPa

Elongation (L=4d) : 25 %

Welding Technique :

For best results re-dry the electrodes at 250°C for 2 hours before use. Clean the weld area completely free of oil, grease, paints, rust or any other foreign matter. For welding heavy sections in cast steel and low alloy steel, preheating of the part may prove beneficial. Use short arc and stringer beads.

Current Conditions : DC (+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	170-200	140-170	90-120	60-80
(Amps)				