LoTherme

Estd. 1966 DNH sécheron Complete Welding Support

LoTherme - 430

Low heat input electrode for welding of AISI 430 and equivalent 17% chromium steels. Martensitic Stainless Steel Deposits withstand Cavitation Erosion.

Characteristics :

LoTherme-430 is a low heat input electrode depositing a weld metal containing 17% chromium. The weld deposit displays good resistance to Cavitation Erosion.

Applications :

LoTherme-430 is ideally suited for Welding of stainless steel AISI 430 and equivalent 17% chromium steels. For overlay on carbon steel, low alloy steels, and chromium steels.

It is appropriate electrode, where the service conditions require good resistance to corrosion, cavitation and heat up to 550°C. Typical applications include surfacing of valves, impellers, hydro-turbine pelton wheel, and valve seats.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	54 kgf/mm^2
ELONGATION (L=4d)	:	22 %
HARDNESS AS DEPOSITED	:	250 - 300 BHN

Welding Technique :

Keeping the electrodes dry. For best results, redry the electrodes at 250-300°C for one hour before use. Clean the weld are thoroughly free of any foreign matter. Use low current, short arc and stringer beads.

Current Conditions : DC (+)/AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	100-130	80-110	70-90