



# LoTHERME



## LoTherme - 444H

**A unique electrode for surfacing of valves & valve seats, steel plant hot metal rolls.**

### **Characteristics :**

- Unique deposit high temperature metal to metal wear on steel plant rolls.
- A special purpose electrode for hard-facing of valves & rollers.
- Excellent operating characteristics.
- Weld metal having excellent crack resistance.
- Weld metal possesses excellent resistance to corrosion, erosion, pitting, & abrasion.

### **Applications :**

LoTherme-444H is ideally suited for surfacing components subjected to high temperature metal to metal wear, corrosion, erosion combined with abrasion. Typical applications include rebuilding of runners, hardfacing of valves & valve seats, pulp & paper machinery, continuous casting rolls & rolls subjected to high temp in steel Rolling mills.

**Weld Metal Hardness:** 400 - 500 BHN

### **Welding Technique :**

Keep the electrodes dry. In case of moisture pick up, re-dry at 200-250°C for one hour. Clean the weld area thoroughly free of any foreign matter. Use low current, short arc and stringer beads.

### **Current Conditions : DC(+) /AC**

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	150-180	120-150	80-110	60-80
(Amps)				