



LOTHERME



LoTherme - 456

Low heat input AC/DC, all position versatile stainless steel electrode for high corrosion resistant applications.

Characteristics :

LoTherme-456 is characterized by excellent operational features on DC as well as AC power sources, a quit, soft and stable arc, which is easy to strike and restrike, good slag detachability and evenly rippled beads. The weld metal is strong, tough and ductile.

Applications :

LoTherme-456 is ideally suited for joining stainless steels to carbon steels, low alloy steels, cast steels and austenitic manganese steels for overlay welds. Typical applications include valve seats, pump impeller, shafts, etc. for chemical dairy, brewery and food industries. Deposits withstand acid corrosion & suitable for welding AISI 316L type stainless steel.

Typical Mechanical Properties Of All Weld Metal :

Ultimate Tensile Strength : 560 MPa

Elongation (L=4d) : 30 %

Welding Technique :

For best results, re-dry the electrodes at about 250°C for one hour before use. Clean Weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) /AC

Size (mm) 5x350 4x350 3.15x350 2.5x350

Dia x Length

Current Range 140-170 100-130 80-100 60-90

(Amps)