



LOTHERME



LoTherme-468(CL)

Low heat input high strength, high alloy electrode for crack-free welds on steels of widely varying compositions.

Characteristics :

LoTherme-468(CL) produces a weld deposit having excellent crack resistance on a variety of steels. It operates equally well on AC as well as on DC (+) in all conventional welding positions. It gives extremely low spatters and easily detachable slag. Very smooth weld finish which takes high polish.

Applications :

It is ideally suited for high strength joints subject to services under wear, impact heat and corrosion, on stainless steels, dissimilar steels, alloy steels and difficult steels including surfacing hot dies, points and crossing, gear teeth, forged shafts, earth moving equipment machine parts, pressure vessels, salt water pipe lines, leaf and coil springs, It is equally ideal for use as buffer layer prior to applying hardfacing alloys.

Typical Mechanical Properties of All Weld Metal:

Ultimate Tensile Strength : 80 kgf/mm²

Elongation (L=4d) : 22%

Welding Technique :

Dry the electrode at about 200°C for an hour before use. Clean the weld area free from oil, grease, dirt or any other surface contamination. Hold a short arc. Do not weave the electrode. Weld with stringer beads. Intermittent welds may be necessary for welding high alloy and hardenable steels.

Current Conditions : DC (+) / AC

Size (mm) 5 x 350 4 x 350 3.15 x 350 2.5x350

Dia x Length

Current Range 125-145 95-115 75-95 55-75

(Amps)