



# LOTHERME



## LoTherme - 468 (SPL)

A special purpose electrode for low heat input welding of austenitic manganese steel.

### Characteristics :

LoTherme-468 (SPL) produces a weld deposit having excellent crack resistance on a variety of steels particularly austenitic Mn steels. The metal exhibits a pleasing operating characteristics with good slag detachability.

### Applications :

LoTherme-468 (SPL) is ideally suited for welding of austenitic manganese steel components to themselves and to mild steel. It is also suited for buffer layers on these steels as well as carbon steels. Ideal for joining of manganese steel liners and other austenitic manganese steel components with steel casting to IS:1030 Gr. 230-450W /280-520W or to IS:2062.

### Weld Metal Hardness :

As Welded : 220 BHN  
Work hardens under impact up to : 450-550 BHN

### Welding Technique :

Ensure the electrodes are dry and in case of moisture pick up, re-dry the electrodes at 250°C for one hour. Ensure cleanliness of the weld area and use short arc, lowest current possible and stringer beads.

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	130-170	90-120	60-90