



# LoTHERME



## LoTherme - 469

**A low heat input electrode for crack free, high strength welds on all steels.**

### **Characteristics :**

LoTherme-469 is an ideal low heat input electrode for high strength welds on steels. Pleasing operating characteristics, smooth weld beads, high strength crack resistant weld metal are features associated with this electrode.

### **Applications :**

Ideally recommended for high strength joints in steels, dissimilar joints in carbon, low alloy steels, dissimilar joints in carbon steels to stainless steels, etc., Typical applications include gears, dies, shafts, earth moving machinery, general machine parts, etc.

### **Typical Mechanical Properties of All Weld Metal:**

Ultimate Tensile Strength : 785 MPa

### **Welding Technique :**

The electrodes should be dry. Re-dry the moist electrodes at 250°C for one hour. Use short arc and stringer beads. Use Pre-heating wherever necessary.

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-180	90-110	70-90	50-70