



# LOTHERME



## LoTherme - 470

**A versatile low heat input electrode for crack free welds on a variety of steels especially for joining SS to CS.**

### **Characteristics :**

LoTherme-470 is a low heat input electrode ideally suited for producing crack free welds on a variety of steels. It operates equally well on AC as well as DC (+) in all conventional positions. Smooth weld beads, extremely low spatter are some of the features associated with this electrode.

### **Applications :**

Ideal for repair and maintenance welding on a variety of steels; dissimilar joints between carbon, low alloy steels to other steels, stainless steels, etc., surfacing applications; ideal for buffer layers before hardfacing. Ideal for joining and building up of a number of components in earthmoving and mining, thermal power, cement, sugar, general engineering industries.

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

Ultimate Tensile Strength : 620 MPa

### **Welding Technique :**

The electrodes should be dry. Re-dry if necessary at 250°C for one hour. Clean the weld area of all contaminants. Use short arc stringer beads. Use preheat wherever necessary.

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	125-145	95-115	75-95	55-75