



LOTHERME



LoTherme - 483

Low heat input electrode depositing low carbon high Cr - high Ni - Mo -Cu weld metal.

Characteristics :

LoTherme-483 is a special DC (+) electrode producing a low carbon Cr-Ni-Mo-Cu weld metal which resists Sulfuric acid, Phosphoric acid corrosion environment. It is characterized by quite and stable arc, which is easy to strike and restrike, finely rippled smooth weld beads and good slag detachability.

Applications:

LoTherme-483 is ideally suited for welding similar composition materials to itself and to other grades of stainless steels.

Typical Mechanical Properties of All Weld Metal:

Ultimate Tensile Strength : 530 MPa

Elongation (L=4d) : 34 %

Welding Technique :

Welding zone must be clean and free from residues, such as grease, paint or metal dust. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input. The electrodes should be kept dry. Re-dry the electrodes at 200-250°C for one hour before use.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	140-170	100-140	80-100	50-70
(Amps)				