



# LoTHERME



## LoTherme - 703

**Low heat input electrode for high-strength machinable deposit. Highly suitable for crack-free joining of Cast Iron to Steel.**

### **Characteristics :**

LoTherme-703 produces high strength, machinable welds and overlays on grey and alloy cast irons. Deposits are even crack-free on joints of Cast Iron to Steels. A stable arc and evenly rippled, smooth beads are some of the many pleasant features of the electrode.

### **Applications:**

LoTherme-703 is used for :

1. Welding grey cast iron, malleable iron and S.G. iron ;
2. Welding cast iron to steel and to nickel alloys and ;
3. Repair welds and rectification of defects in castings.

Typical applications include engine heads, pump castings, impellers, rope drums, ingot moulds and a variety of cast iron machine parts. Due to the high strength and ductility, LoTherme-703 is ideal for welding heavy and highly stressed cast iron sections.

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

Ultimate Tensile Strength : 420 MPa

Weld Metal Hardness : 190 BHN

### **Welding Technique :**

For joining bevel the edges to 75-90° in single or double 'Vee' groove according to thickness of the parts. For repair of cracks, drill holes at the two ends of the crack to arrest its further propagation. Remove entire cracked material to sound metal by chipping, gouging or machining. Clean the weld area free of grease, oil, paints, etc. prior to welding. Re-dry the electrode at 150°C for one hour before use. Weld short beads not exceeding 50 mm at a time. Each bead should be peened when still hot. For large and heavy sections pre heating of the job may be necessary. After the welding is completed, the castings should be covered completely with a layer of asbestos or dry lime until it attains room temperature.

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	130-170	100-130	85-120	50-70
(Amps)				