



LoTHERME



LoTherme - 704 N

Universally applicable electrode with a specially designed bimetallic core wire having high penetration even on oil soaked C.I.

Characteristics :

The electrodes have a stable arc and produce a flat seam. Particularly for fillet welds an optimal seam structure is achieved. Due to the bimetallic core wire, the current carrying capacity and the deposition rate are excellent. The weld deposit is highly crack resistant and easily machinable.

Applications:

LoTherme-704N is suitable for joining and surfacing of grey cast iron, nodular cast iron (spheroidal cast iron) and malleable cast iron as well as for joining these materials each other or with steel and cast steel.

Typical Mechanical Properties Of All Weld Metal:

Ultimate Tensile Strength : 395 MPa
Weld Metal Hardness : 200 BHN

Welding Technique :

LoTherme-704N is preferably welded on DC (-) or on AC. When welding on DC (-) a deep penetration is reached in fillet welds. Position welding are easier with AC. Re-dry the electrode at 150°C for one hour before use. Prior to welding, remove the casting skin. Hold electrode vertically and with short arc. When welding crack susceptible cast iron grades, the deposit may be peened.

Current Conditions : DC(-) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
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Dia x Length

Current Range	140-170	110-130	90-110	65-80
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(Amps)