



LOTHERME



LoTherme - 457 IVR

Specially developed low heat electrode for resurfacing rail points and crossings.

Characteristics :

LoTherme-457 IVR has been formulated to produce extra tough and crack resistant weld metal. The weld metal exhibits excellent resistance to rolling and sliding friction, and impact. The weld metal work hardens under impact.

The electrode possesses pleasing operating characteristics and produces smooth, well-rippled weld beads.

Applications :

LoTherme-457 IVR has been specially developed for resisting rolling and sliding friction, and impact service conditions as encountered by rail points and crossings. It is ideally suited for resurfacing rail points and crossings, worn-out rails, etc. in order to enhance the service life. LoTherme -457 IVR is recommended for both buffer and surface layers.

Typical Mechanical Properties Of All Weld Metal :

HARDNESS As Welded	:	220 BHN
Work hardens (under impact)	:	450-550 BHN

Welding Technique :

Keep the electrodes dry. In case of moisture pick-up, they should be re-dried at 250°C for minimum one hour. Clean the area thoroughly of all contaminants. Use low current, short arc and stringer beads.

Current Conditions : DC(+) /AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	130-170	90-120	60-90