



LOTHERME HF-45M



Characteristics & Applications :

Lotherme HF-45M is a composite wire especially for the steel industry as weld overlay for continuous caster rolls. Modified carbon composition provides higher hardness when compare to Lotherme HF-45. Addition of Alloys resist the formation of thermal fatigue cracks. Wire has Excellent corrosion & wear resistance properties. Typical application is steel mill continuous caster rolls.

Typical Chemical Composition of All Weld Metal (%):

Element	C	Mn	Si	P	S	Cr	Ni	Mo	V	Nb	Fe
Typical	0.20	1.00	0.30	0.030	0.030	12.5	0.60	1.40	0.20	0.20	Bal.

Typical Mechanical Properties of All Weld Metal :

Weld Metal hardness after 3rd layer on MS Plate with Lotherme SAF-704 (AW)- 46-52 HRC

Current And Packing Data : DC (+)

Size (mm)	Current (A)	Volt.(V)	Wire Extension(mm)
3.2	400-500	26-30	31-38
4.0	450-600	28-32	31-38

Packaging :

Standard wire size is 3.2 & 4.0 mm. The wire is supplied in a layer wound 25 kg metallic ring packed in a shrink-wrapped corrugated box. Wire is also available in 200/250kg card-board drum packing packed on a pallet. Flux is supplied in 25kg poly-lined bag.