



LOTHERME HF-18



Composite submerged arc welding wires recommended with Maxflux SAF-704 flux for re-building of Rollers

DESCRIPTION:

LOTHERME HF-18 is a composite SAW wire of 0.5– 1.2 Cr, 1 to 2 % Ni, low carbon with controlled addition of Silicon & Molybdenum for buffer layer deposits. The weld metal has excellent bonding property, resistance to solidification cracking and is easily machinable.

MAXFLUX SAF-704 is an agglomerated basic flux, shall be re-dried at 350°C before use.

APPLICATIONS:

LOTHERME HF-18 wire is used for buffer layer prior to hard-surfacing of higher carbon (>0.25%) CC rolls and equivalent grade steel rolls. Single layer deposit is recommended as buffer layer.

For surface re-building, the wire can be used on multi-layers welding.

ALL-WELD METAL COMPOSITION (with LOTHERME SAF-704 FLUX):

Wire	C	Mn	Si	Cr	Ni	Mo	N
LOTHERME HF-18	0.08 max	0.50-1.20	0.60 max	0.5 - 1.2	1.0-2.0	0.20-0.50	0.06-0.15

WELD METAL HARDNESS :

LOTHERME HF-18 & LOTHERME SAF-704 flux, on 3-layer	20-25 HRC
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WELDING CURRENT & STICK OUT (Polarity: DC +):

Wire diameter, mm	Current, Amp	Voltage, V	Linear travel speed, mm/min
3.2	350 – 450	28 – 30	400 – 500

PACKAGING:

Standard wire size is 3.2mm. 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.

An ISO 9001: 2018 certified company

D&H Sécheron Electrodes Private Limited

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