



LOTHERME



LoTherme - 476

Low heat input, high strength, high alloy electrode for crack-free welds.

Characteristics :

LoTherme-476 producing welds which have free from cracking on a various types of similar and dissimilar steels including hardened steels. It operates in all conventional welding positions. It has extremely low spatter and easy slag detachability with spray metal transfer.

Applications :

LoTherme-476 is ideally suited for high strength, crack-free welds and overlays subject to services under wear, friction, impact, heat and corrosion on mild carbon, low alloy, stainless and dissimilar steels. Typical applications include welding on dies, tools, leaf and coil springs and similar parts and surfacing hot dies, gear teeth, forget shafts, earth moving equipment and machine parts. It is suitable for rebuilding in construction and mining industries.

Typical Mechanical Properties of All Weld Metal:

Ultimate Tensile Strength : 820 MPa

Elongation (L=4d) : 25%

Welding Technique :

Ensure the electrodes are dry. Re-dry the electrode at 250°C for one hour before use. Clean the weld area completely free of oil, grease, paint, rust or any other foreign matter. Use low current, short arc and stringer beads. For certain high alloy tool steels preheating is recommended.

Current & Packing Data: DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-180	110-140	80-110	60-90