LOTHERME

Estd. 1966 DH sécheron Complete Welding Support

LoTherme - 430

Low heat input electrode for welding of AISI 430 and equivalent 17% chromium steels. Martensitic Stainless Steel Deposits withstand Cavitation Erosion.

Characteristics :

LoTherme-430 is a low heat input electrode depositing a weld metal containing 17% chromium. The weld deposit displays good resistance to Cavitation Erosion.

Applications :

LoTherme-430 is ideally suited for Welding of stainless steel AISI 430 and equivalent 17% chromium steels. For overlay on carbon steel, low alloy steels, and chromium steels.

It is appropriate electrode, where the service conditions require good resistance to corrosion, cavitation and heat up to 550°C. Typical applications include surfacing of valves, impellers, hydro-turbine pelton wheel, and valve seats.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	54 kgf/mm^2
ELONGATION (L=4d)	:	22 %
HARDNESS AS DEPOSITED	:	250 - 300 BHN

Welding Technique :

Keeping the electrodes dry. For best results, redry the electrodes at 250-300°C for one hour before use. Clean the weld are thoroughly free of any foreign matter. Use low current, short arc and stringer beads.

Current Conditions : DC (+)/AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	100-130	80-110	70-90

LoTherme - 444 H

A unique electrode for surfacing of valves & valve seats, steel plant hot metal rolls.

Characteristics :

- Unique deposit high temperature metal to metal wear on steel plant rolls.
- A special purpose electrode for hard-facing of valves & rollers.
- Excellent operating characteristics.
- Weld metal having excellent crack resistance.
- Weld metal possesses excellent resistance to corrosion, erosion, pitting, & abrasion.

Applications :

LoTherme-444H is ideally suited for surfacing components subjected to high temperature metal to metal wear, corrosion, erosion combined with abrasion. Typical applications include rebuilding of runners, hardfacing of valves & valve seats, pulp & paper machinery, continuous casting rolls & rolls subjected to high temp in steel Rolling mills.

WELD METAL HARDNESS : 400 - 500 BHN As Welded.

WELDING TECHNIQUE :

Keep the electrodes dry. In case of moisture pick up, they should be re-dried at 200-250°C for one hour. Clean the weld area throughly free of any foreign matter.

Use low current, short arc and stringer beads.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	150-180	120-150	80-110	60-80

Estd. 1966
DH sécheron
Complete Welding Support

LOTHERME

50 YEARS 1966 - 2016

LoTherme - 444 L

Martensitic Stainless Steel Electrode with High Strength for increased resistance to cavitation erosion.

Characteristics :

LoTherme-444L especially designed for the fabrication and repair welding of hydro turbine components made of soft martensitic SS 13% Cr-4%Ni alloyed steels and cast steel. Suitable for reclamations of ASTM CA6NM casting, Continuous Casting Rolls, etc.

Applications :

LoTherme-444L is well suited welding electrode for joining and building up on corrosion resistant martensitic Cr - Ni steels and the corresponding cast steels. The welding deposit has an increased resistance against cavitations and erosion also at working temperatures up to 350°C.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	79 kgf/mm^2
ELONGATION (L=4d)	:	17 %
Hardness As Welded	:	330 - 400 BHN
CVN IMPACT STRENGTH (@RT)	:	60 Joules

Welding Technique :

Weld the electrode slightly inclined with a short arc. Re-drying 2-3 hours at 250-300°C. For wall thickness more than 10mm, preheating base metal to 150°C is recommended.

Current Conditions : DC(+) /AC

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

LoTherme - 451

Stabilized low carbon electrode for Cr Ni Mo Steel

Characteristics :

LoTherme-451 produces deposits of extra low carbon with balanced Cr - Ni ratio and controlled ferrite. Furthermore, stabilisation with Niobium ensures excellent resistance to corrosion. The presence of molybdenum improves the corrosion resistance in reducing media. Easy arc striking and re-striking, excellent weld finish and good slag detachability are some of the many pleasant features associated.

Applications :

LoTherme-451 is well suited for welding AISI 316, 316L, 316Ti, 317, 318, 318Ti, and other molybdenum bearing stainless steels, which find extensive applications in paper, fertilizer, oil refining and chemical industries. The extra low carbon coupled with columbium in the weld deposit ensures excellent resistance to carbide precipitation and the resultant intergranular corrosion.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	61 kgf/mm^2
ELONGATION (L=4d)	:	35 %

Welding Technique :

For best results, dry the electrodes at about 250°C for one hour before use. Clean Weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) /AC

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

LoTherme

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Estd. 1966
Complete Welding Support

LoTherme - 452

Low heat input AC/DC, all position, extra low carbon electrode for Food & Pharma Grade Stainless Steel.

Characteristics :

LoTherme-452 produces weld deposits of extra low carbon with balanced Cr-Ni ratio and controlled ferrite of outstanding resistance to hazards of cracking, weld decay, corrosion and pitting.

Excellent weld finish, easy striking and restriking, stable arc and good slag detachability are a few among many pleasant features associated with LoTherme-452.

Applications :

LoTherme-452 is ideally suited for welding AISI stainless steels types 201, 301, 302, 304, 304L, 308, 308L and their equivalents. The extra low carbon in the weld deposit ensures freedom from carbide precipitation and resultant intergranular corrosion.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	53 kgf/mm^2
ELONGATION (L=4d)	:	35 %

Welding Technique :

For best results, dry the electrodes at about 250°C for one hour before use. Clean Weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	90-130	70-90	50-70

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Complete Welding Support

LOTHERME

50 YEARS

LoTherme - 453

Low heat input AC/DC, ALL POSITION Cr-Ni-Nb stabilized electrode with Nb.

Characteristics :

LoTherme-453 produces Nb stabilized weld deposits with balance Cr-Ni ratio and controlled ferrite for excellent resistance to corrosion.

The electrode is characterized by soft and stable arc, which is easy to strike and re-strike, finely rippled weld beads of radiographic quality and easily detachable slag.

Applications :

LoTherme-453 is ideally suited for low heat input welding on AISI 301, 302, 304, 304L, 308, 308L, 321 and 347 stainless steel which are used in oil refining, chemical, paper pigments and paints, brewery, dairy and food processing industries. The welds have excellent resistance to carbide precipitation and the resultant inter-granular corrosion.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	54 kgf/mm^2
ELONGATION (L=4d)	:	30 %

Welding Technique :

For best results, dry the electrodes at about 250°C for one hour before use. Clean Weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	90-130	70-90	50-70

LoTherme

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LoTherme - 455

Low heat input AC/DC, all position extra low carbon Cr-Ni electrode with Molybdenum.

Characteristics :

LoTherme-455 produces deposits of extra low carbon with balanced Cr-Ni ratio and controlled ferrite. Furthermore, stabilization with columbium ensures excellent resistance to corrosion. The presence of molybdenum improves the corrosion resistance in reducing media.

Easy arc striking and re-striking, excellent weld finish and good slag detachability are some of the many pleasant features associated with LoTherme-455.

Applications :

LoTherme-455 is well suited for welding AISI 316, 316L, 316Ti, 317, 318, 318Ti, and other molybdenum bearing stainless steels, which find extensive applications in paper, fertilizer, oil refining and chemical industries.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	54 kgf/mm^2
ELONGATION (L=4d)	:	30 %

Welding Technique :

For best results, dry the electrodes at about 250°C for one hour before use. Clean Weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	90-130	70-90	50-70

LoTherme - 456

Low heat input AC/DC, all position versatile stainless steel electrode for high corrosion resistant applications.

Characteristics :

LoTherme-456 is characterized by excellent operational features on DC as well as AC power sources, a quit, soft and stable arc, which is easy to strike and restrike, good slag detachability and evenly rippled beads. The weld metal is strong, tough and ductile.

Applications :

LoTherme-456 is ideally suited for joining stainless steels to carbon steels, low alloy steels, cast steels and austenitic manganese steels for overlay welds. Typical applications include valve seats, pump impeller, shafts, etc. for chemical dairy, brewery and food industries. Deposits withstand acid corrosion & suitable for welding AISI 316L type stainless steel.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	57 kgf/mm^2
ELONGATION (L=4d)	:	30 %

Welding Technique :

For best results, dry the electrodes at about 250°C for one hour before use. Clean Weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	100-130	80-100	60-90

LoTherme - 457

Special electrode for low heat input welding and surfacing of austenitic manganese steels and steels of widely varying composition for progressive work hardening.

Characteristics :

LoTherme-457 produces weld deposits, which display excellent resistance to impact in combination with corrosion. The special features include, soft and stable arc, which is easy to strike and re-strike, well rippled smooth weld beads and good slag detachability.

Applications :

The balanced chemistry of LoTherme-457 results in high quality welds on a wide range of similar and dissimilar steels, such as joining of austenitic manganese steels to themselves, and to Carbon Steels. Other applications include welding of heat treatable alloy steels for fabrication welding, maintenance and reclamation of worn-out parts, both for buffer layer and hardfacing in mining, cement, steel, power plant, earth moving machinery, etc.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	62 kgf/mm^2
ELONGATION (L=4d)	:	35 %
HARDNESS As Welded	:	200 BHN

Work hardens (under impact) to 450 - 550 BHN

Welding Technique :

Keeping the electrodes dry. In case of moisture pick up, redry at 250°C for minimum one hour. Clean the weld area thoroughly free of any foreign matter. Use low current, short arc and stringer beads.

Current Conditions : DC (+)/AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	120-160	80-100	55-80

Also available as LoTherme 457 HD for high deposition rate.

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LOTHERME

50 YEARS 1966 - 2016

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

LoTherme - 458

A versatile electrode for low heat input welding of Stainless steels to carbon Steels and for overlays.

Characteristics :

LoTherme-458 produces welds of RADIOGRAPHIC quality and for joining SS to Steels, resistance to corrosion. Evenly rippled, extremely smooth weld beads. Soft and stable arc, which is easy to strike and re-strike. Good slag detachability.

Applications :

LoTherme-458 is ideally suited for :

(1) Welding stainless steel AISI 309 and similar compositions in wrought or cast form ;

(2) Joining 18/8 stainless steel to mild steel ;

(3) Welding the clad side of 18/8 stainless steel ;

(4) Applying sheet linings of 12% Cr or 17% Cr steel to mild steel Shells ;

(5) Overlays on carbon steels and low alloy steels for superior corrosion resistance.

Typical applications include chemicals pumps and a number of other machinery and equipment.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	57 kgf/mm^2
ELONGATION (L=4d)	:	30 %

Welding Technique :

Keep the electrode dry. Redry moist electrodes at 250°C for one hour. Use low current, short arc length and stringer beads.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	90-130	70-100	50-70

Estd. 1966
D&H sécheron
Complete Welding Support

LOTHERME

50 YEARS 1966 - 2016

LoTherme - 464

Low heat input, special purpose stainless steel electrode for welding stainless steels and steels to resist scaling upto 1100°C.

Characteristics :

LoTherme-464 is characterized by a stable arc, which is easy to strike and re-strike. Easily removable slag, smooth finely rippled welds of RADIOGRAPHIC quality. The weld metal is fully austenitic in structure and possesses high strength, high ductility, good toughness and creep strength. Resistance to scaling is retained up to 1100°C.

Applications :

LoTherme-464 is ideally suited for welding of stainless steel AISI 310 to itself and to other steels, straight chromium stainless steels, dissimilar steels, including steels of relatively high harden ability, clad steels, carbon-molybdenum and chromium-molybdenum piping. Some of the typical applications include welding of heat kiln anchors, exchanges, heat-treating pots and boxes, furnace parts, etc.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	56 kgf/mm^2
ELONGATION (L=4d)	:	30 %

Welding Technique :

Dry the electrode at 250°C for one hour before use. Keep the interpass temperature as low as possible by using current and low heat input. Use short arc and stringer beads.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	90-130	70-100	50-70

LoTherme - 467

A heat resistant stainless steel electrode with molybdenum for low heat input welding and overlays, on most types of stainless carbon steel. Deposit resists high temperature & corrosion.

Characteristics :

LoTherme-467 is characterized by quiet and stable arc, which is easy to strike and restrike, finely rippled, smooth weld beads and good slag detachability.

Applications :

LoTherme-467 is a 'universal' electrode suited for welding all grades of steels where high strength and corrosion resistance in combination with heat resistance are important factors. For welding of straight chromium stainless steel such as AISI 410, and 430 LoTherme-467 is the appropriate electrode.

Typical applications of LoTherme-467 include salvaging pumps, valves and shafts operating at high temperature. Also suitable for hot dies and overlays on cast iron.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	68 kgf/mm^2
ELONGATION (L=4d)	:	30 %

Welding Technique :

For best results dry the electrodes at about 250°C for one hour before use. Clean weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) /AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	110-130	80-100	60-80

LoTherme - 468

A universal low heat input high strength, high alloy electrode for crack-free welds and overlays on steels of widely varying compositions. Unique Dissimilar Steel joining alloy.

Characteristics :

LoTherme-468 filler wire and flux material are so chosen that it is highly favourable for producing welds which have complete freedom from hazards of cracking on a wide variety of similar and dissimilar steels. It operates equally well on AC as well as on DC(+) in all conventional welding positions. Extremely low spatter. Easily detachable slag. Very smooth weld finish, which takes high polish, hence suitable for frictional wear resistance.

Applications :

LoTherme-468 is ideally suited for high strength, crack-free welds and overlays subject to services under wear, friction, impact, heat & corrosion on carbon, low alloy, molybdenum-vanadium spring, tool and die, stainless and dissimilar steels. Typical applications include dies, tools, leaf and coil springs and similar parts and surfacing hot dies, gear teeth, forged shafts, earth moving equipment and machine parts.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	85 kgf/mm^2
ELONGATION (L=4d)	:	23 %

Welding Technique :

Dry the electrode at about 125°C for one hour before use. Clean the weld area free from oil, grease, dirt or any other surface contamination. Hold a short arc. Do not weave the electrode. Weld with stringer beads. Intermittent welds may be necessary for welding high alloy and hardenable steels. Peening will relieve internal stresses. For certain high alloy tool steels preheating is recommended.

Current Conditions : DC(+) / AC

Size (mm) 5x350 Dia x Length	4x350	3.15x350	2.5x350	
Current Range (Amps)	140-170	100-130	75-95	60-80

LoTherme - 468 (SPL)

A special purpose electrode for low heat input welding of austenitic manganese steel.

Characteristics :

LoTherme-468 (SPL) produces a weld deposit having excellent crack resistance on a variety of steels particularly austenitic Mn steels. The metal exhibits a pleasing operating characteristics with good slag detachability.

Applications :

LoTherme-468 (SPL) is ideally suited for welding of austenitic manganese steel components to themselves and to mild steel. It is also suited for buffer layers on these steels as well as carbon steels. Ideal for joining of manganese steel liners and other austenitic manganese steel components with steel casting to IS:1030 Gr. 230-450W /280-520W or to IS:2062.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	220 BHN
Work hardens under impact upto	:	450-550 BHN

Welding Technique :

Ensure the electrodes are dry and in case of moisture pick up, redry the electrodes at 250°C for one hour. Ensure cleanliness of the weld area and use short arc, lowest current possible and stringer beads.

Current Conditions : DC(+) / AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	150-170	90-120	70-100	60-90

Estd. 1968
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50 YEARS 1968 - 2018

LoTherme - 468 XCEL

Characteristics :

LoTherme-468 XCEL producing welds which have complete freedom from cracking on a wide variety of similar and dissimilar steels including hardened steels. It operates in all conventional welding positions. It has extremely low spatter and easy slag detach ability with spray metal transfer.

Applications :

LoTherme-468 XCEL 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, molybdenum-vanadium spring, tool and die, 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: 85 kgf/mm^2

Welding Technique :

Keep the electrode dry, in case of moisture pick up, they should be re-dried at 200-250°C for one hour. Clean the weld area thoroughly free of any foreign matter. Use low current, short arc and stringer beads. Peen to relieve stresses.

Current & Packing Data: AC / DC(+)

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	125-145	95-115	75-95	55-75

LoTherme - 469

A low heat input electrode for crack free, high strength welds on all steels.

Characteristics :

LoTherme-469 is an ideal low heat input electrode for high strength welds on steels. Pleasing operating characteristics, smooth weld beads, high strength crack resistant weld metal are features associated with this electrode.

Applications :

Ideally recommended for high strength joints in steels, dissimilar joints in carbon, low alloy steels, dissimilar joints in carbon steels to stainless steels, etc., Typical applications include gears, dies, shafts, earth moving machinery, general machine parts, etc.

Typical Ultimate Tensile Strength Of Weld Metal :

80 Kgf/mm^2

Welding Technique :

The electrodes should be dry. Redry the moist electrodes at 250°C for one hour. Use short arc and stringer beads. Use Pre-heating wherever necessary.

Current Conditions : DC(+) / AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	150-180	90-110	70-90	50-70

LOTHERME

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LoTherme - 470

A versatile low heat input electrode for crack free welds on a variety of steels especially for joining SS to CS.

Characteristics :

LoTherme -470 is a low heat input electrode ideally suited for producing crack free welds on a variety of steels. It operates equally well on AC as well as DC (+) in all conventional positions. Smooth weld beads, extremely low spatter are some of the features associated with this electrode.

Applications :

Ideal for repair and maintenance welding on a variety of steels; dissimilar joints between carbon, low alloy steels to other steels, stainless steels, etc., surfacing applications; ideal for buffer layers before hardfacing. Ideal for joining and building up of a number of components in earthmoving and mining, thermal power, cement, sugar, general engineering industries.

Typical Ultimate Tensile Strength Of Weld Metal :

65 Kgf/mm^2

Welding Technique :

The electrodes should be dry. Redry if necessary at 250°C for one hour. Clean the weld area of all contaminants. Use short arc stringer beads. Use preheat wherever necessary.

Current Conditions : DC(+) / AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	125-145	95-115	75-95	55-75

Also available as LoTherme 470 M for higher critical joining applications in mining Industry.

LoTherme - 483

Low heat input electrode depositing low carbon high Cr - high Ni - Mo -Cu weld metal.

Characteristics :

LoTherme-483 is a special DC (+) electrode producing a low carbon Cr-Ni-Mo-Cu weld metal which resists Sulfuric acid, Phosphoric acid corrosion environment. It is characterized by quite and stable arc, which is easy to strike and restrike, finely rippled smooth weld beads and good slag detachability.

Applications:

LoTherme-483 is ideally suited for welding similar composition materials to itself and to other grades of stainless steels.

Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	54 Kgf/mm^2
ELONGATION (L=4d)	:	34 %

Welding Instructions:

Welding zone must be clean and free from residues, such as grease, paint or metal dust. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input. The electrodes should be kept dry. Redry the electrodes at 200-250°C for one hour before use.

Current Conditions : DC(+)

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	140-170	100-140	80-100	50-70

LoTherme

Estd. 1966
DH sécheron
Complete Welding Support

LoTherme - 485

Low-carbon, fully austenitic electrode, High Cr-Ni-Mo-C alloy having high corrosion resistance.

Characteristics :

LoTherme-485 distinguishes itself particularly by resistance to tension cracks and pitting in media containing chloride. This alloy has remarkably high corrosion resistance against phosphoric acid and exhibits very low excavation rates in sulphuric media. The electrode can be welded in all positions, except vertical down. The seam has a finely rippled, smooth and regular structure.

Applications :

LoTherme-485 electrode for joining and surfacing of base materials of the same and of similar nature.

Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	54 Kgf/mm^2
ELONGATION (L=4d)	:	31 %

Welding Instructions :

Welding zone must be clean and free from residues, such as grease, paint or metal dust. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input. The electrodes should be kept dry. In case of moisture pick-up re-dry the electrodes at 250°C for one hour.

Current Conditions : DC(+) / AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	160-200	120-160	80-120	60-90