



LOTHERME



LoTherme - 210 R

A medium coated electrode for low heat input welding of mild steel with minimal distortion.

Characteristics :

LoTherme-210R produces excellent weld finish at extremely low current. It can be used in all conventional positions. Finely rippled weld beads, soft and steady arc, radiographic quality weld and self-detachable slag are a few among many pleasant features associated with LoTherme-210R.

Applications :

LoTherme-210R has been designed for welding sheet metal in low heat input technique. It can also be used for welding mild steel of higher thickness depending on the applications. This electrode can be used for fabrication and repairing of Buckles, Gear cases, Protector tubs, Door patches, Side panels, End wall patches etc. of rolling stocks and locomotives.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	48 kgf/mm ²
ELONGATION (L=4d)	:	27 %

Welding Technique :

Keep the electrode dry. Clean the weld area free of any surface contamination. Use low current and short arc technique. While welding sheet metal, it will be of greater advantage if the job can be placed in an inclined position and welded down-hill. This will also help in increasing welding output.

Current Conditions : AC/DC (±)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	160-200	130-160	90-120	50-80
(Amps)				