



# LOTHERME



## LoTherme - 353

**A low heat input electrode for welding carbon steel.**

### Characteristics :

LoTherme-353 is a electrode operating in all conventional positions depositing a high strength weld metal. The deposits are of radiographic quality and display excellent ductility and toughness.

### Applications :

LoTherme-353 is ideally suited for welding mild, medium carbon steels of medium tensile strength. Ideal electrode having excellent operational characteristics for welding carbon steels where a high joint strength is required. The electrode has a high metal recovery and is ideal for achieving faster welding speed and welding output.

### Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	54 kgf/mm <sup>2</sup>
ELONGATION (L=4d)	:	28 %

### Welding Technique :

Redry the electrodes at 250°C for one hour before use. Clean the weld area free of contaminants. Use low current and short arc technique.

### Current Conditions : DC (+)/AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-200	120-160	90-120	60-90