

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