

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