

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