



LoTHERME



LoTherme - 457

Special electrode for low heat input welding and surfacing of austenitic manganese steels and steels of widely varying composition for progressive work hardening.

Characteristics :

LoTherme-457 produces weld deposits, which display excellent resistance to impact in combination with corrosion. The special features include, soft and stable arc, which is easy to strike and re-strike, well rippled smooth weld beads and good slag detachability.

Applications :

The balanced chemistry of LoTherme-457 results in high quality welds on a wide range of similar and dissimilar steels, such as joining of austenitic manganese steels to themselves, and to Carbon Steels. Other applications include welding of heat treatable alloy steels for fabrication welding, maintenance and reclamation of worn-out parts, both for buffer layer and hardfacing in mining, cement, steel, power plant, earth moving machinery, etc.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	62 kgf/mm ²
ELONGATION (L=4d)	:	35 %
HARDNESS As Welded	:	200 BHN

Work hardens (under impact) to 450 - 550 BHN

Welding Technique :

Keeping the electrodes dry. In case of moisture pick up, redry at 250°C for minimum one hour. Clean the weld area thoroughly free of any foreign matter. Use low current, short arc and stringer beads.

Current Conditions : DC (+)/AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	140-170	120-160	80-100	55-80

Also available as LoTherme 457 HD for high deposition rate.