



LOTHERME



LoTherme - 467

A heat resistant stainless steel electrode with molybdenum for low heat input welding and overlays, on most types of stainless carbon steel. Deposit resists high temperature & corrosion.

Characteristics :

LoTherme-467 is characterized by quiet and stable arc, which is easy to strike and restrike, finely rippled, smooth weld beads and good slag detachability.

Applications :

LoTherme-467 is a 'universal' electrode suited for welding all grades of steels where high strength and corrosion resistance in combination with heat resistance are important factors. For welding of straight chromium stainless steel such as AISI 410, and 430 LoTherme-467 is the appropriate electrode.

Typical applications of LoTherme-467 include salvaging pumps, valves and shafts operating at high temperature. Also suitable for hot dies and overlays on cast iron.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	68 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	110-130	80-100	60-80