

## LoTherme - 468 XCEL

### Characteristics :

LoTherme-468 XCEL producing welds which have complete freedom from cracking on a wide variety of similar and dissimilar steels including hardened steels. It operates in all conventional welding positions. It has extremely low spatter and easy slag detach ability with spray metal transfer.

### Applications :

LoTherme-468 XCEL is ideally suited for high strength, crack-free welds and overlays subject to services under wear, friction, impact, heat and corrosion on mild carbon, low alloy, molybdenum-vanadium spring, tool and die, stainless and dissimilar steels. Typical applications include welding on dies, tools, leaf and coil springs and similar parts and surfacing hot dies, gear teeth, forget shafts, earth moving equipment and machine parts. It is suitable for rebuilding in construction and mining industries.

### Typical Mechanical Properties of All Weld Metal:

ULTIMATE TENSILE STRENGTH: 85 kgf/mm<sup>2</sup>

### Welding Technique :

Keep the electrode dry, in case of moisture pick up, they should be re-dried at 200-250°C for one hour. Clean the weld area thoroughly free of any foreign matter. Use low current, short arc and stringer beads. Peen to relieve stresses.

### Current & Packing Data: AC / DC(+)

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	125-145	95-115	75-95	55-75