LoTherme - 468

A universal low heat input high strength, high alloy electrode for crack-free welds and overlays on steels of widely varying compositions. Unique Dissimilar Steel joining alloy.

Characteristics :

LoTherme-468 filler wire and flux material are so chosen that it is highly favourable for producing welds which have complete freedom from hazards of cracking on a wide variety of similar and dissimilar steels. It operates equally well on AC as well as on DC(+) in all conventional welding positions. Extremely low spatter. Easily detachable slag. Very smooth weld finish, which takes high polish, hence suitable for frictional wear resistance.

Applications :

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

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	85 kgf/mm^2
ELONGATION (L=4d)	:	23 %

Welding Technique :

Dry the electrode at about 125°C for one hour before use. Clean the weld area free from oil, grease, dirt or any other surface contamination. Hold a short arc. Do not weave the electrode. Weld with stringer beads. Intermittent welds may be necessary for welding high alloy and hardenable steels. Peening will relieve internal stresses. For certain high alloy tool steels preheating is recommended.

Current Conditions : DC(+) / AC

Size (mm) 5x350 Dia x Length	4x350	3.15x350	2.5x350	
Current Range (Amps)	140-170	100-130	75-95	60-80