



LOTHERME



LoTherme - 470

A versatile low heat input electrode for crack free welds on a variety of steels especially for joining SS to CS.

Characteristics :

LoTherme -470 is a low heat input electrode ideally suited for producing crack free welds on a variety of steels. It operates equally well on AC as well as DC (+) in all conventional positions. Smooth weld beads, extremely low spatter are some of the features associated with this electrode.

Applications :

Ideal for repair and maintenance welding on a variety of steels; dissimilar joints between carbon, low alloy steels to other steels, stainless steels, etc., surfacing applications; ideal for buffer layers before hardfacing. Ideal for joining and building up of a number of components in earthmoving and mining, thermal power, cement, sugar, general engineering industries.

Typical Ultimate Tensile Strength Of Weld Metal :

65 Kgf/mm²

Welding Technique :

The electrodes should be dry. Redry if necessary at 250°C for one hour. Clean the weld area of all contaminants. Use short arc stringer beads. Use preheat wherever necessary.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
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Dia x Length

Current Range	125-145	95-115	75-95	55-75
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(Amps)

Also available as LoTherme 470 M for higher critical joining applications in mining Industry.