

LoTherme - 512

Low heat input electrode for high strength and corrosion resistant welds on Monel and other Ni-Cu alloys.

Characteristics :

LoTherme -512 is a hydrogen controlled, low heat input welding electrode. Good weld finish with good slag detachability. Versatile in applications for maintenance welding.

Applications :

LoTherme-512 electrode core wire and flux formulation are so balanced as to make it a versatile electrode for welding of monel to monel, to other Ni-Cu alloys, Ni-Cu alloys to themselves, Ni-Cu Alloys to steels, the clad side of Ni-Cu clad steel and for surfacing steel parts for service against corrosion by sea water, chlorinated solvents, sulphuric acid and alkalis. Ideal for power plants, chemical, food, dairy and oil refining industries.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	57 Kgf/mm ²
ELONGATION (L=4d)	:	30 %

Welding Technique :

The electrode should be stored dry. In case of moisture pick-up, redry them to 250°C for one hour before use. Clean the weld area free of surface contamination of any form. Use short arc and weld with stringer beads. Wherever possible weld in flat position.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350	2x300
Dia x Length					
Current Range (Amps)	140-170	105-135	70-100	50-70	35-50