



LOTHERME



LoTherme - 515 N

Extreme Corrosion resistance electrode with high Nickel content.

Characteristics :

LoTherme-515 N electrode is weld-able in all positions, except vertical down. Stable arc, good slag remove-ability. The seam is finely rippled and notch-free. It gives a fully austenitic weld metal without hot cracks, not prone to embrittlement either at high or low temperatures.

Applications :

LoTherme-515 N is recommended for cold-tough steels up to 9% Ni and working temperatures down to minus 196°C, particularly where the welded joint has to undergo hot deformation or stress relieving. Cold tough austenitic Cr - Ni steels can also be welded with LoTherme-515 N. This electrode is also suitable for joining different materials, such as austenitic to ferritic stainless steel, steels to Nickel alloys and steels to Copper alloys.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	63 Kgf/mm ²
ELONGATION (L=4d)	:	35 %
CVN IMPACT STRENGTH (@RT)	:	85 Joules
-----"----- (at Minus 196°C)	:	55 Joules

Welding Instructions :

Ensure that the electrodes are dry. In case of moisture pick-up, dry the electrodes at 250°C for 2 hours before use. Clean the weld area free of rust, oil, grease, paint, or any other surface contamination. To ensure minimal heat input, use short arc and stringer bead technique.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	160-200	120-160	80-120	60-90
(Amps)				