Estd. 1966
DNH sécheron
Complete Welding Support

LOTHERME

50 YEARS

LoTherme - 516 N

Extreme Scale resistant electrode with High Ni-Cr Alloy with High No content for high temperature applications.

Characteristics :

LoTherme-516 N has excellent welding properties, a regular and finely rippled bead appearance due to spray arc. Very easy slag removal. The weld deposit is highly corrosion resistant, scale resistant and work hardening. Machinable with cutting tools. Resistance to hot cracking for service temperature up to 1100°C.

Applications :

LoTherme-516 N electrode for cladding & joining and surfacing high-temperature Ni-Cr-Mo alloys. Special applications are in oxidizing media at high temperatures, especially for the construction of gas turbines, combustion chambers and ethylene production plants, journals, trimming dies, etc.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	72 Kgf/mm^2
ELONGATION (L=4d)	:	32 %
CVN IMPACT STRENGTH (@RT)	:	90 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) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	160-200	120-160	80-120	60-90