



# LOTHERME



## LoTherme - 534

**Aluminium Bronze electrode for sea water corrosion resistance.**

### Characteristics :

LoTherme-534 possesses outstanding welding properties and can be used in all positions, except vertical down. The weld metal displays high mechanical properties and is tough, pore-less and not prone to cracking.

### Applications:

LoTherme-534 is used for joining and surfacing on aluminium-bronzes (up to 10% Al), copper and copper alloys as well as surfacing on steel, cast steel and cast iron. It is also suitable for welding pipe cavities in new aluminium-bronze castings. Its corrosion resistance allows it to be used on marine propellers, acid pumps and fittings.

### Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	46 Kg/mm <sup>2</sup>
ELONGATION (L=4d)	:	20 %

### Welding Instructions:

Clean the weld zone thoroughly. Wall thickness in excess of 5 mm must be grooved out with a 90°V. Bigger work-pieces are preheated to about 150-250°C. To avoid overheating, guide the electrode vertically at high welding speed. Use only dry electrodes. Electrodes that have got damp must be dried 2 to 3 hours at 250°C.

### Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	130-160	80-110	70-90