

## LoTherme - 535

**Complex aluminium-bronze electrode with high mechanical properties and sea water resistant**

### Characteristics :

LoTherme-535 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. It work hardens to give excellent resilience to wear.

### Applications:

LoTherme-535 is used for joining and surfacing on complex aluminium-bronzes, especially those with high Mn, as well as steel and grey cast iron. It is also eminently suited for shipbuilding (marine propellers, pumps and fittings) and in the chemical industry (valves, pumps) where chemical attack is accompanied by erosion. Its favorable coefficient of friction makes it ideal for surfacing on shafts, sliding surfaces, bearings, punches and dies of all kinds.

### Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	66 Kgf/mm <sup>2</sup>
ELONGATION (L=4d)	:	25 %

### 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 200-250°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)	150-190	120-160	80-120	60-90