



LOTHERME



LoTherme - 705

Low heat input electrode producing outstanding quality machinable welds on cast iron.

Characteristics :

LoTherme-705 flux formulation is so chosen that the electrode produce extremely soft arc which is essential for low heat input and avoiding dilution of weld metal with harmful elements present in the parent metal. The electrode produces crack free machinable welds.

Applications:

LoTherme-705 is ideally suited for sound, crack free welds on grey cast iron, spheroidal iron, malleable cast iron to themselves, to each other, to steel, or to monel or copper alloys. Equally good for cladding, filling, surfacing and building up of worn-out parts or broken sections. Repair welding of valve bodies, sprockets, engine blocks, pump casings, gears, machine base and defective castings are some of the various applications of LoTherme-705.

Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	35 Kgf/mm ²
HARDNESS	:	150 BHN

Welding Technique :

Dry the electrode at 150°C for one hour before use. Clean weld area free of all surface contamination. Bevel broken parts or crack areas to about 70° Vee. For cold welding, use as low a current as possible and deposit short weld beads not exceeding 50 mm. Peen the welds. Pre-heating of the part is not necessary.

Current Conditions : AC / DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	125-165	95-125	65-105	45-65