

LoTherme - 210

Exclusive electrode for low heat input welding of mild steel with minimal distortion.

Characteristics :

LoTherme-210 flux formation is so chosen that the electrode produces excellent weld finish at extremely low current. It can be used on AC/DC (\pm) in all conventional positions.

Finally rippled weld beads, soft and steady arc which is easy to strike and re-strike and self-detachable slag are a few among many pleasant features associated with LoTherme-210.

Applications :

LoTherme-210 has been specially designed for welding sheet metal with low heat input technique in order to prevent distortion. However, it can also be used for welding mild steel of higher thickness.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	48 kgf/mm ²
ELONGATION (L=4d)	:	28 %

Welding Technique :

Keep the electrode dry. Clean the weld area free of any surface contamination. Use low current and short arc technique. While welding sheet metal, it will be of greater advantage if the job can be placed in an inclined position and welded downhill. This will also help in increasing welding output.

Current Conditions : AC/DC (\pm)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	140-200	110-160	80-120	50-80