

LoTherme - 352 R

A low heat input electrodes for mild, medium carbon steels, cast steels and for buffer layers.

Characteristics :

LoTherme-352R is a low heat input AC/DC electrode, operates equally well in all conventional positions. High quality, high strength, crack free radiographic welds are the special features of LoTherme-352R. Welds display excellent ductility and toughness.

Applications :

LoTherme-352R is suitable for repair of bogies, both cast and fabricated. Also suitable for welding mild, medium carbon steels, difficult steels, steels heavy structures, repair of Co-Co bogies, plant and equipment subject to dynamic loading and impact. It is also suitable for depositing buffer layers before hard surfacing.

Typical Mechanical Properties Of All Weld Metal :

| | | |
|---------------------------|---|------------------------|
| ULTIMATE TENSILE STRENGTH | : | 57 kgf/mm ² |
| ELONGATION (L=4d) | : | 26 % |

Welding Technique :

Redry the electrodes at 250°C for one hour before use. Clean the weld area completely free of oil, grease, paint, rust or any other foreign matter. For welding heavy sections in cast steel, preheating of the part may prove beneficial. Use short arc.

Current Conditions : DC (+)/AC

| | | | | |
|-------------------------|---------|---------|----------|---------|
| Size (mm) | 5x350 | 4x350 | 3.15x350 | 2.5x350 |
| Dia x Length | | | | |
| Current Range (Amps) | 170-210 | 140-170 | 100-130 | 60-90 |