



LOTHERME



LoTherme - 352

Hydrogen controlled electrode for mild, medium carbon, high strength steels, cast steels, "problem steels", and for cushion layer under hard deposits.

Characteristics :

LoTherme-352 is a hydrogen controlled electrode, operates equally well in all conventional positions. High quality, high strength, crack-free RADIOGRAPHIC welds are the special features of LoTherme-352. Welds display good ductility and impact resistance at ambient and sub-zero temperatures.

Applications :

LoTherme-352 is ideally suited for welding mild, medium carbon, high tensile steels, difficult steels, steels high in sulphur and phosphorus, heavy structures, plant and equipment subjected to dynamic loading and impact. It is equally good for depositing buffer layer before hard surfacing.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	56 kgf/mm ²
ELONGATION (L=4d)	:	28 %

Welding Technique :

For best results, dry the electrode at 250°C for two hours 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, pre-heating 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	170-210	140-170	110-140	60-90
(Amps)				