



LOTHERME



LoTherme - 444 H

A unique electrode for surfacing of valves & valve seats, steel plant hot metal rolls.

Characteristics :

- Unique deposit high temperature metal to metal wear on steel plant rolls.
- A special purpose electrode for hard-facing of valves & rollers.
- Excellent operating characteristics.
- Weld metal having excellent crack resistance.
- Weld metal possesses excellent resistance to corrosion, erosion, pitting, & abrasion.

Applications :

LoTherme-444H is ideally suited for surfacing components subjected to high temperature metal to metal wear, corrosion, erosion combined with abrasion. Typical applications include rebuilding of runners, hardfacing of valves & valve seats, pulp & paper machinery, continuous casting rolls & rolls subjected to high temp in steel Rolling mills.

WELD METAL HARDNESS : 400 - 500 BHN As Welded.

WELDING TECHNIQUE :

Keep the electrodes dry. In case of moisture pick up, they should be re-dried at 200-250°C for one hour. Clean the weld area thoroughly free of any foreign matter.

Use low current, short arc and stringer beads.

Current Conditions : DC(+) /AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-180	120-150	80-110	60-80