



LOTHERME



LoTherme - 452

Low heat input AC/DC, all position, extra low carbon electrode for Food & Pharma Grade Stainless Steel.

Characteristics :

LoTherme-452 produces weld deposits of extra low carbon with balanced Cr-Ni ratio and controlled ferrite of outstanding resistance to hazards of cracking, weld decay, corrosion and pitting.

Excellent weld finish, easy striking and restriking, stable arc and good slag detachability are a few among many pleasant features associated with LoTherme-452.

Applications :

LoTherme-452 is ideally suited for welding AISI stainless steels types 201, 301, 302, 304, 304L, 308, 308L and their equivalents. The extra low carbon in the weld deposit ensures freedom from carbide precipitation and resultant intergranular corrosion.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	53 kgf/mm ²
ELONGATION (L=4d)	:	35 %

Welding Technique :

For best results, dry the electrodes at about 250°C for one hour before use. Clean Weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	140-170	90-130	70-90	50-70