



# LOTHERME



## LoTherme - 485

**Low-carbon, fully austenitic electrode, High Cr-Ni-Mo-C alloy having high corrosion resistance.**

### Characteristics :

LoTherme-485 distinguishes itself particularly by resistance to tension cracks and pitting in media containing chloride. This alloy has remarkably high corrosion resistance against phosphoric acid and exhibits very low excavation rates in sulphuric media. The electrode can be welded in all positions, except vertical down. The seam has a finely rippled, smooth and regular structure.

### Applications :

LoTherme-485 electrode for joining and surfacing of base materials of the same and of similar nature.

### Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	54 Kgf/mm <sup>2</sup>
ELONGATION (L=4d)	:	31 %

### Welding Instructions :

Welding zone must be clean and free from residues, such as grease, paint or metal dust. Use stringer beads, short arc and smallest possible size, which helps in reducing the heat input. The electrodes should be kept dry. In case of moisture pick-up re-dry the electrodes at 250°C for one hour.

### Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	120-160	80-120	60-90