



LOTHERME



LoTherme - 511 N

Low heat input electrode for welding Ni-Cr-Fe alloys and dissimilar steels experiencing high temperature.

Characteristics :

LoTherme-511 N is operates in all conventional positions. The weld deposit is hot cracking resistant and does not tend to embrittlement. The weld metal working significantly after more than 10,000 hours at temperature up to 850°C. Has exceptional impact properties, with excellent lateral expansion.

Applications :

LoTherme-511 N is used for joining or cladding heat resistant Ni Cr Fe alloys, Inconel Alloys heat, resistant austenitic steels, heat resistant austenitic ferrite materials, Ni-Cr-Fe materials, joining of dissimilar steels, nickel based alloys.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	61 Kgf/mm ²
ELONGATION (L=4d)	:	36 %
CVN IMPACT STRENGTH (@RT)	:	90 Joules
-----"----- (at Minus 196°C)	:	60 Joules
HARDNESS	:	190 BHN

Welding Technique :

Dry the electrodes 250°C for 2 hours before use. Clean the weld area free of rust, oil, grease, paint, or any other surface contamination. To ensure minimal heat input, use short arc and stringer bead technique.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-180	110-140	70-100	50-70