



LOTHERME



LoTherme - 513

Low heat input electrode depositing practically pure nickel for wrought and cast Nickel and Ni Alloys

Characteristics :

LoTherme-513 is a special purpose electrode, versatile in applications in the field of fabrication and maintenance welding of machinery and equipment. It is meant for use with DC reverse polarity in all conventional positions. Finely rippled even weld beads. Stable arc, which is also easy to strike and restrike. Good slag detachability.

Applications :

LoTherme-513 is so designed as to deposit practically pure nickel. It is highly useful for welding nickel in wrought and cast forms, pure nickel to themselves and for joining nickel to steels, for surfacing carbon and low-alloy steels. It is an ideal electrode for building up worn out or missing sections, repairing defects and cladding mild steel for chemical, food, dairy and oil refining industries. It is also ideal for overlays on parts used for caustic soda service.

Typical Mechanical Properties Of All Weld Metal :

ULTIMATE TENSILE STRENGTH	:	43 Kg/mm ²
ELONGATION (L=4d)	:	22 %

Welding Technique :

Dry the electrode at 250°C for one hour before use. Clean the weld area free of any surface contamination. Use DC reverse polarity, short arc, stringer beads. Control the heat input to as low a level as possible by allowing the weld to cool before depositing subsequent passes. Wherever possible, weld in flat position.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	140-170	110-140	80-110	55-75