



# LOTHERME



## LoTherme - 536

**A specially formulated low-heat input 70/30 alloy for Cupro-Nickel welding.**

### Characteristics :

LoTherme-536 is a copper - nickel electrode, for joining and surfacing of wrought and cast alloys of similar composition as well as 80/20 and 90/10 alloys. It operates in all conventional positions.

### Applications:

LoTherme-536 is used in offshore applications because of its good resistance to the corrosion in seawater. It is also suitable for ship-building, chemical process equipments, oil refineries, food industries, etc.

### Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	40 Kg/mm <sup>2</sup>
ELONGATION (L=4d)	:	28 %

### Welding Instructions:

Clean the weld zone thoroughly. Wall thickness in excess of 5 mm must be grooved out with a 90°V. Bigger work-pieces are preheated to about 200-250°C. To avoid overheating, guide the electrode vertically at high welding speed. Use only dry electrodes. Electrodes that have got damp must be dried 2 to 3 hours at 250°C.

### Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	130-160	100-130	80-100	60-90
(Amps)				