

## LoTherme - 702

**A low heat input, Ni-Cu alloy (monel) type electrode for machinable welding of cast iron.**

### Characteristics :

LoTherme-702 is a nickel-copper alloy electrode for low heat input welding of cast iron without preheating. The welds are sound, strong and easily machinable. The electrode displays a soft and steady arc, which is easy to strike and restrike and ability to operate on low currents.

### Applications:

LoTherme-702 is suited for joining of broken cast iron parts, repairing defects in cast iron foundry and repairs of fractured iron parts in all welding positions. Typical applications include **rebuilding of worn out surface, gear teeth, pump impellers, etc.**

### Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH	:	34 Kg/mm <sup>2</sup>
HARDNESS	:	160 BHN

### Welding Technique :

Dry the electrode at 150°C for one hour before use. Clean the base material thoroughly free of any surface contamination. Use short weld runs followed by peening. In case of repair welding on castings, remove entire defective portion to sound metal prior to welding.

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	140-170	100-130	80-100	50-70