



# LOTHERME



## LoTherme - 704

**A low heat input, high nickel electrode for better machinability deposit on cast iron.**

### Characteristics :

LoTherme-704 is a low heat input electrode, which deposits a very high nickel alloy. The arc is stable even at low current ranges, and this minimises dilution of weld metal with harmful elements present in the parent metal. Slag coverage is complete and slag detachability is excellent. The deposit bonds soundly with the parent metal and the beads are smooth and dense. The welds are machinable.

### Applications:

LoTherme-704 is ideally suited for sound, crack-free welds on grey cast iron, S.G. iron, malleable iron and for joining cast irons to steels and to nickel-copper alloys. It is equally good for corrosion resistant overlays, filling and building up of worn out parts and joining broken sections. Typical applications are repair welding on machine bases, motor blocks, heavy castings, valve bodies, sprockets, pumps castings and gears.

### Typical Mechanical Properties Of All Weld Metal:

ULTIMATE TENSILE STRENGTH : 35 Kgf/mm<sup>2</sup>  
HARDNESS : 140 BHN

### Welding Technique :

Redry the electrode at 150°C for one hour before use. Clean weld area free from any surface contamination. Bevel broken parts or cracks to 70-80° Vee. Use a short arc and as low a current as possible. Deposit short weld beads not exceeding 25 mm. Peen the weld to relieve internal stresses and allow the work-piece to cool slowly to room temperature. Pre-heating of the part is generally not necessary.

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	125-165	95-125	65-95	45-65