

## LoTherme OA - 610

### A Stainless Steel base Work-hardening type OA wire

#### Characteristics :

LoTherme OA-610 is an open arc self shielded flux cored wire giving a 16% Cr-4% Mn deposit. The weld metal has excellent abrasion resistance property combine to good resistance to cracking, corrosion, erosion and metal-to-metal wear.

#### Applications:

LoTherme OA-610 wire is especially designed for the hard-surfacing, overly and buffer layer applications of various components & parts made of carbon steel, low alloy steel and austenitic manganese steel. Applications include, surfacing of mining & excavation components, cement mill parts, steel plant rolls & roll crushers, etc.

#### Weld Metal Hardness:

HARDNESS: AS WELDED	: 220-250 BHN
WORK HARDENED	: 450-500 BHN

#### Current Conditions : DCEP/DCRP/DC(+)

Diameter (mm)	2.4	2.8
Current Range (Amps)	200-300	250-350
Voltage (V)	26-28	26-28
Stick Out (mm)	30-40	30-40

#### Standard Wire Diameter (mm): 2.4 and 2.8

#### Packing:

Supplied in layer wound 12.5 kgs plastic spool. Each spool is sealed in a polythene bag and then packed in a shrink-wrapped corrugated box.

**Note :** Any other type of packaging may be available on request.