



LOTHERME



LoTherme - 602 B

A basic electrode, with high recovery, for moderately hard deposit, especially on high tensile ferrous metals, that are heat treatable, well suited for difficult to weld steels in forging industries.

Characteristics :

LoTherme-602 B is characterised by a stable arc, good slag detachability and weld beads of fine appearance. It operates well on conventional positions.

Applications:

LoTherme-602 B is a highly crack resistant, even in multiple layer deposit, ideally suited for a number of applications, which demand good impact resistance, combined with high degree of toughness. It can be used on mild steel, carbon steel, low alloy steels, etc. where an as-welded hardness of 33-40 HRC is required. Some of the typical application include gears, shafts, crane wheels, brake shoes, forging dies, drive sprockets, conveyor parts, cold punching dies, rails ends, log wheels, ploughshares, wobblers, etc.

Weld Metal Hardness : 320 - 380 BHN (As Welded)

Welding Technique :

The electrode should be stored dry. Re-dry at 250°C for 1 hour before use. Use low current and short arc. Avoid excessive weaving. For base materials with carbon content of 0.30% and above, use buffer layers with LoTherme-352 before surfacing. When welding hardenable steels of large thickness, adequate care for preheating, slow cooling after welding & PWHT are recommended for best result.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	170-210	140-170	90-130	N.A.