

LoTherme - 602

Low heat input, touch-weld, low manganese electrode for moderately hard deposit to resist impact & frictional wear. It is a flame hardenable alloy.

Characteristics :

LoTherme-602 is characterised by a stable arc, which is easy to strike and restrike, good slag detachability and weld beads of fine appearance. It operates equally well on AC as well as DC in all conventional positions.

Applications:

LoTherme-602 is ideally suited for a number of applications, which demand good abrasion resistance, combined with fairly high degree of toughness. It can be used on mild steel, carbon steel, low alloy steels, etc., where hardness of 250-300 BHN is required. Some of the typical applications include gears, shafts, crane wheels, brake shoes, forging dies, drive sprockets, conveyor parts, cold punching dies, rail ends, log wheels, ploughshares, wobblers, etc.

Weld Metal Hardness : 280 - 380 BHN

Welding Technique :

The electrode should be stored dry. In case of moisture pick-up, Re-dry at 150°C for one hour before use. Use low current and short arc. Avoid excessive weaving. For base materials with carbon content of 0.3% and above, use buffer layers with LoTherme-352 before surfacing.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-190	130-160	95-120	55-75