

LoTherme - 603 R

Rutile-coated, touch-welding, H/F electrode for wear resistant surfacing on wide range of machine components.

Characteristics :

LoTherme-603 R has excellent welding properties, a homogeneous, finely rippled bead appearance due to the spray arc and very easy slag removal. This electrode is weldable with very low amperage settings (advantage for edge buildup).

Applications:

LoTherme-603 R is used for wear resistant buildups for abrasion and impact applications. Typical applications include surfacing chipper knives, conveyor bucket lips, shovels dredger and elevator bucket lips, rock crushers, rock drills, tractor grousers and paddlers.

Weld Metal Hardness : 55 - 60 HRC

Welding Instructions :

Preheat high-alloy tool steels to 400-450°C and maintain this temperature during the whole welding process. Hold electrode vertically with a short arc and lowest possible amperage setting. Machining only by grinding. Re-dry electrodes that have got damp for 1 hour at 100°C.

Current Conditions : AC / DC (±)

| | | | | |
|----------------------|---------|---------|----------|---------|
| Size (mm) | 5x350 | 4x350 | 3.15x350 | 2.5x350 |
| Dia x Length | | | | |
| Current Range (Amps) | 150-180 | 110-150 | 80-110 | 60-90 |