



LOTHERME



LoTherme - 610

An outstanding, low heat input electrode for hard-facing and applying buffer and cushion layers on a wide variety of austenitic manganese steel components, with progressive work hardening.

Characteristics :

LoTherme-610 yields a weld metal, which has high toughness and abrasion resistance in combination with excellent resistance to deformation and cracking. Ideally suited for depositing buffer layers on hard austenitic manganese steel surface.

Applications:

LoTherme-610 is ideally suited for hardfacing, overlay, buffer, and cushion layer applications on a variety of components on mild steel, carbon steel, low alloy steel and austenitic manganese steel. Typical applications include surfacing mining machinery, dredging equipment, excavator parts, mill hammers, cement mill air rings, crusher hammers, roll crusher, muller tyres, shovel tracks, coal mining cutters, tractor grousers, dipper teeth, sand pump impellers, valve seats, etc.

Weld Metal Hardness : 280-380 BHN (As welded)

Work hardens under impact to : 480-550 BHN

Welding Technique :

For best results, dry electrodes at 250°C for one hour before use. Clean weld surface thoroughly free of any surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) / AC

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	160-190	110-150	80-100	50-70