

LoTherme - 612

Co-Cr-W-alloy of Cobalt Grade 12 hard-facing resisting heat, corrosion and wear.

Characteristics :

LoTherme-612 welds well in the horizontal position. Soft arc, smooth seam surface. Very high resistance to combined abrasion and impact stressing under high temperatures. Corrosion- resistant.

Applications:

LoTherme-612 is given preference where corrosion, abrasion and impact stressing are imposed simultaneously. Typical specific applications are cutters and tools for processing plastics, wood and paper, as well as highly stressed sealing and sliding surfaces.

Typical Mechanical Properties Of All Weld Metal:

AT ROOM TEMPERATURE	:	37-45 HRC
AT 600°C	:	35-40 HRC

Welding Technique:

Clean the weld zone of rust, scale and grease. Bigger work pieces are preheated to about 250°C. Keep the amperage as low as possible, so as to fuse the parent metal as little as possible. Guide the electrode vertically, keeping the arc short. Weave only slightly. Cool slowly in an oven or under asbestos. Machinable by grinding.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	120-160	80-120	60-90