

## LoTherme - 618 S

**"Spray" electrode for roughening the cast-iron cane crushing rolls in the SUGAR industry. Equally efficient in both Wet & Dry arcing.**

### **Characteristics :**

LoTherme-618 S has an aggressive "spray" type arc with excellent penetration to allow application while the mill is in operation. By attaching the earth clamp to the gearbox housing, arcing in the bearing area is avoided. It has been developed to resist the extreme load produced during crushing. The deposit is highly abrasion-resistant and also corrosion-resistant.

### **Applications:**

The application of LoTherme-618 S electrode on sugar mill rollers improves the grip on the cane, increases the quantity of sugar cane crushed and, consequently, results in a higher sugar recovery.

### **Weld Metal Hardness on the Carbide :**

ON CARBON STEEL : 55 - 60 HRC

ON CAST IRON : 58 - 62 HRC

### **Welding Instructions :**

Hold electrode vertical to work piece. Keep stable arc on moving roll for full spraying effect.

### **Current Conditions : DC(+) / AC**

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	170-200	140-170	100-140	70-100