



LOTHERME



LoTherme - 624BE

Low heat input, low hydrogen electrode having excellent resistance to abrasion at elevated temperature.

Characteristics :

- Low heat input, low hydrogen, Ni-Mo alloy based electrodes.
- Electrode producing a weld metal having exceptional resistance to wear to combat abrasion, impact, and retain hardness at elevated temperatures.
- Soft and stable arc, which is easy to strike and re-strike.

Applications:

LoTherme-624 BE is ideally suited for hardfacing machine parts and components subject to combination of heavy abrasion, metal-to-metal wear, moderate impact and hardness at elevated temperatures. Typical applications include surfacing such as hot shears, blast furnace bells, tong teeth, hoppers, valve seats, guide plates, etc.

Weld Metal Hardness :

As Deposited	:	50 - 53 RC
At 550°C	:	40 - 43 RC

Welding Technique :

Remove all damaged and fatigued metal before deposition. Use short arc and stringer bead technique. Keep the electrodes dry. In case of moisture pick-up, redry at 250°C for an hour before use.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	190-220	160-185	120-150	80-100