

## LoTherme - 625

**Low heat input hard-facing electrode for reconditioning of worn-out MM steel and Gr. 90A points and crossings for use in high traffic density 35 GMT.**

### Characteristics :

LoTherme-625 is characterized by producing easy work hardening and highly wear resistible austenitic 17%Cr-15%Mn- 3% Ni weld metal. The electrode possesses pleasing operating characteristics and produces smooth, well-rippled weld beads.

### Applications:

LoTherme-625 is ideally suited for welding high manganese steel such as rail crossings and points, jaw and roll crushers, crusher hammers, crushing blades, etc.

Weld Metal Hardness : 200-300 BHN (As welded)  
After work hardening : 400-470 BHN

### Welding Technique :

Keep the electrode dry. In case of moisture pick up, they should be rebaked at 250°C for one hour. Clean the weld area thoroughly free of any foreign matter, Use low current, short arc and stringer beads,

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	200-250	160-190	130-160	100-130