



# LOTHERME



## LoTherme - 627

**A special low heat input hardfacing electrode.**

### **Characteristics :**

LoTherme-627 is a specially formulated low heat input hard-facing electrode for the reclamation of rolls, crane wheels, etc. The electrode has pleasing operating characteristics. The weld metal has excellent resistance to heat and rolling friction and resistance to wear at elevated temperatures. The weld deposit is machinable for smooth finish.

### **Applications:**

The weld metal is ideally suited for the reclamation of steel mill rolls and other similar applications involving roll friction and elevated temperature wear.

Weld Metal Hardness : 280 - 380 BHN

### **Welding Technique :**

Keep the electrode dry. In case of moisture pick-up, redry at 150°C for an hour before use. Clean the weld area free of any surface contamination. Use short arc and stringer bead technique.

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

|                      |         |         |          |         |
|----------------------|---------|---------|----------|---------|
| Size (mm)            | 5x350   | 4x350   | 3.15x350 | 2.5x350 |
| Dia x Length         |         |         |          |         |
| Current Range (Amps) | 160-200 | 130-160 | 90-120   | 60-90   |