

LoTherme - 628

Low heat input electrodes depositing air hardening weld metal for hardfacing.

Characteristics :

LoTherme-628 is a low heat input electrode specially designed for hardfacing and build-up of worn out machine parts and components. Welds are highly resistance to abrasive wear and possesses moderate toughness. It can be used in all conventional positions. Soft and stable arc, which is easy to strike and restrike, well rippled smooth weld beads and good slag detachability are the special operating characteristics.

Applications:

LoTherme-628 has versatility of applications in areas of building-up worn out parts and hard-facing. It can be use directly on the job without the necessity of putting a buffer layer. Some of the typical applications including surfing / rebuilding of shafts, chain sheaves, dies, shares, sprockets, rail ends & crossings, pulleys, idler wheels.

Weld Metal Hardness : 290-390 BHN

Welding Technique :

Keep the electrodes dry. For best results, redry the electrodes at 250°C for one hour before use. 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)	180-220	130-160	80-110	70-90