



LOTHERME



LoTherme - 629

Low heat input electrodes for versatile hard-facing applications.

Characteristics :

LoTherme-629 is a low heat input electrode specially designed for hardfacing and build-up of worn out machine parts and components. Welds are abrasive wear resistance 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-629 is versatility of applications in areas of building-up worn out parts and hardfacing. It can be use directly on the job without the necessity of putting a buffer layer. Some of the typical applications include surfacing / 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