



LOTHERME



LoTherme - 650 P

High Heat & Tempering Resistant Alloy for Surfacing of Mandrels, Hot Piercing Plugs.

Characteristics :

LoTherme-650P has excellent welding properties, a homogeneous, finely rippled seam and a self-lifting slag.

Applications:

LoTherme-650P is suited for heat resistant buildups on hot working steels particularly exposed to metallic gliding wear and elevated shock stress, such as die cast molds for brass, aluminum and magnesium, hot piercing plugs, hot pressed mandrills, trimming tools, hot shear blades, extruding tools, forging dies and hot flow pressing tools for steel. Due to the excellent metal to-metal gliding properties, also suitable for buildups on guiding and gliding surfaces. Tempering resistant up to 650°C, scale resisting up to 900°C.

Weld Metal Hardness :

AS WELDED	:	47 - 52 RC
ANNEALED AT 850 - 900°C	:	35 RC
HARDENED AT 1100 - 1150°C	:	48 - 52 RC
TEMPERED AT 700°C	:	40 RC

Welding Instructions :

Clean welding area to metallic bright. Preheating temperature depends on the welding application (150-240°C). On low-alloy steels at least 3-4 layers should be applied. For best results, re-dry the electrodes at 250°C for one hour before use.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	120-160	80-120	60-90