



LOTHERME



LoTherme - 660 G3

Electrode for high temperature resistant surfacing on hot work steels exposed to impact, compression and friction, especially in a re-rolling mill.

Characteristics :

LoTherme-660 G3 electrode welds well in the horizontal and slightly rising positions. The weld pool is easy to control and the slag is easily removed.

Applications:

On account of its high tensile strength, toughness and high-temperature resistance, LoTherme-660 G3 is employed for surfacing on machine components and tools exposed to impact, compression and friction at operating temperatures up to 550°C, such as cutting edges for cold and hot shear blades, guillotine shears, dies, swages, hammers etc. It is also used to good advantage for the economic manufacture of cold and hot working tools.

Weld Metal Hardness : 46 - 52 RC

Welding Instructions :

Preheat the work piece to 250-300°C. Guide the electrode as vertically as possible, with medium-long arc. Let the work piece cool slowly under asbestos. Finish by grinding. For best results, re-dry the electrodes at 250°C for one hour before use.

Current Conditions : DC(+)

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