

LoTherme - 660 G4

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

Characteristics :

LoTherme-660 G4 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 the strength of its toughness and high-temperature resistance, LoTherme-660 G4 is employed for surfacing on machine components exposed to impact, compression and friction at operating temperatures up to 550°C. Accordingly LoTherme-660 G4 is particularly suited for building-up dies. It can also be used to good effect for surfacing rollers, drive cloverleaves, hot shear blades, etc. It is also employed for the economic manufacture of these work pieces.

Weld Metal Hardness : 37 - 45 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. Subsequent machining with tungsten carbide or 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	130-170	90-120	60-90