



LOTHERME



LoTherme - 684

Low heat input electrodes for high stress grinding abrasion and hard deposit on ferrous metals.

Characteristics :

LoTherme-684 is a low heat input complex carbide electrode, which is easy to strike and restrike having very high abrasion resistance & good slag detachability. Weld beads are of fine appearance. It operates in all conventional positions. The weld metal is designed to give excellent resistance to high stress grinding abrasion, galling and scratching abrasion.

Applications:

It can be used on variety of steels and cast iron. Ideally suited for parts subject to abrasion, impact and compressive load, for sand pump, mining & cement industry, bucket lips, pug mill screw, power-station coal nozzles and coal burners.

Weld Metal Hardness : 57 - 62 RC

Welding Instructions :

- Keep the electrode dry. In case of moisture pick, redry at 150°C for one hour before use.
- Use low current and short arc.
- For base materials with carbon content of 0.3% and above, use buffer layers with LoTherme-352 / 607 before surfacing.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350
Dia x Length			
Current Range (Amps)	150-180	120-150	95-120