

## LoTherme - 603

**Low heat input, basic coated versatile electrode for hard surfacing of widely varying machine parts and components.**

### Characteristics :

LoTherme-603 a hard surfacing electrode, operates well in all conventional positions. The deposited weld metal has exceptional abrasion and wear resistance in combination with resistance to heavy impact. Evenly rippled, porosity free weld deposits permit heavy build-up without danger of cracking. In most cases LoTherme-603 can be used direct on the job without the necessity of depositing buffer layers.

### Applications:

LoTherme-603 core wire and flux formulation are so chosen as to make the electrode versatile in terms of surfacing applications on a large variety of machine parts, equipment, etc. Typical applications include surfacing chipper knives, conveyor bucket lips, shear blades, shovels dredger and elevator bucket lips rock crushers, rock drills, tractor grousers and paddlers. In crushing applications, LoTherme-603 is recommended as the final layer on 14 % manganese weld deposit to reduce the initial wear.

**Weld Metal Hardness** : 52 - 62 RC

**Welding Technique** :

Ensure that the electrodes are perfectly dry before use. In case of moisture pick-up, redry the electrodes at 200°C for one hour before use. Clean the weld area free of any surface contamination. Use AC or DC(+). Hold a short arc length and weld with stringer beads.

### Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350
Dia x Length			
Current Range (Amps)	170-210	140-170	100-130