

LoTherme - 609

A special formulated low hydrogen electrodes for hot shear blades.

Characteristics :

LoTherme-609 is a low heat input electrode depositing a C-W-Co-Cr-V alloy. The electrode has excellent operating characteristics and operates smoothly without posing any difficulty for the welders. The weld metal possesses good toughness and resistance to shock loads. The weld metal retains hardness even at elevated temperatures of 600°C and possesses good resistance to oxidation.

Applications:

LoTherme-609 is ideally suited for reclaiming hot shear blades and components of similar type where retention of elevated temperature hardness is important.

WELD METAL HARDNESS : 55 - 60 RC

Welding Technique :

For best results dry the electrodes at 250°C for one hour before use. Clean the weld area completely free of oil, grease, paints, rust of any other foreign matter. Use short arc and stringer bead technique.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	130-160	90-120	60-90