



LOTHERME



LoTherme - 613

An outstanding low heat input, hard-facing electrode having excellent resistance to abrasion, metal-to-metal wear at ambient as well as at high temperatures and good corrosion resistance.

Characteristics :

LoTherme-613 yields weld deposits, which have excellent resistance to abrasion and metal-to-metal wear in combination with good resistance to corrosion. The weld deposits possess hardness of 48-56 RC. Hardness is retained up to 550°C. A soft and stable arc, which is easy to strike and restrike, good slag detachability and smooth weld profile are some of the many pleasing features associated with LoTherme-613.

Applications:

Where conditions are highly abrasive and also corrosive e.g. flue gases, slurries, etc., LoTherme-613 is the most appropriate electrode.

The capacity to retain hardness at high temperatures, and excellent resistance to abrasion make LoTherme-613 ideally suited for surfacing blast furnace bells and hoppers, conveyor screws, coke, chutes, steel mill grinders, pump impellers, valves, etc.

Weld Metal Hardness : 48 - 55 RC

Welding Technique :

For best result, bake the electrodes at 200°C for one hour before use. Clean weld surface thoroughly free of all surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350
Dia x Length			
Current Range (Amps)	180-220	140-170	100-130