



# LOTHERME



## LoTherme - 619

**Low heat input hard-facing electrode for reconditioning of worn-out MM steel and Gr. 90A points and crossings for use in high traffic density routes.**

### Characteristics :

LoTherme-619 has been formulated to produce strong, tough, easy work hardening and highly abrasion resistible austenitic 15Cr-15Mn-2Ni weld metal. The electrode possesses pleasing operating characteristics and produces smooth, well-rippled weld beads, with easy slag detachability.

### Applications:

LoTherme-619 is ideally suited for welding high manganese steel such as rail crossings, Bulletproof steel plates, Crushing blades, Crushing hammers etc.

Weld metal Hardness : 240-250 BHN (As welded)

After work hardening : 400-470 BHN

### Welding Instructions :

Keep the electrode dry. In case of moisture pick up, they should be rebaked at 250°C for min. one hour. Clean the weld area thoroughly free of any foreign matter, Use low current, short arc and stringer beads,

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

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	160-200	140-180	100-140	70-90