

LoTherme - 660 G2

Electrode for high temperature resistant surfacing of hot work steels exposed to compression and friction especially in a re-rolling mill.

Characteristics :

LoTherme-660 G2 electrode welds well in the horizontal and slightly rising positions. The weld pool is easy to control and the slag is easily removed.

Applications:

On the strength of its great hardness, toughness and high-temperature resistance, LoTherme-660 G2 is employed for surfacing on machine components and tools exposed to friction and compression with moderate impact loads and operating temperatures up 500°C. These include dead centers, tons, slide - and guide ways, hot and cold cut-off attachments, valves, slides, hot shear blades, extrusion press pistons, dies, strippers, deburrers, sheet punching tools. It is also used to good advantage for the economic manufacture of cold and hot working tools.

Weld Metal Hardness : 50 - 57 RC

Welding Instructions :

Preheat the work piece to 250-300°C. Guide the electrode as vertically as possible, with medium-long arc. Let the work piece cool slowly under asbestos. Finish by grinding. For best results, re-dry the electrodes at 250°C for one hour before use.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-200	120-160	80-120	60-90