



## LoTherme – 9580M



**Electrode designed for die rebuilding & surfacing for extra tough hot & cold working tools.**



### Characteristics :

LoTherme-9580M have balanced chemical composition contain with Cr - Ni - Mo and W. It is designed for surfacing / cladding of a new die and re-building of worn-out hot forging dies. The consumables has very good welder appeal and easy slag detachability. It is free from cracks, porosities and any other surface defects.

### Applications :

LoTherme-9580M is suitable for hot & cold work trimmers, shear, blanking & forming dies, punches, coining dies, header dies, forging dies, hot working tools & guides, H-11 & H-12 dies, etc. It has exceptional wear characteristics at high temperature, ideal for press dies and impactor dies. It is also suitable for cold forming application like automotive trim section. Machinability is limited to grinding.

### Weld Metal Hardness (on 3 layers) :

**As Welded : 48-53 HRC**

### Welding Techniques :

Re-dry the electrodes at 250-300°C for One hour. When welding hardenable steels of large thickness, adequate care for preheating, slow cooling & post weld heat treatment are recommended for best results. Pre-heat heavy thickness jobs up to 400°C and maintain this while welding, with short arc, along with peening after every pass is necessary. After welding, cool in still air up to 200°C.

### Electrical Characteristics : DC (+)

Size (mm) Dia x Length	6.3 x 350	5 x 350	4 x 350	3.15 x 350
Current Range (Amps)	250-280	200-250	150-180	100-140