



LoTHERME



LoTherme - 600

Co-Cr-W-alloy of Cobalt Grade 1 for surfacing to resist high temperature wear.

Characteristics :

LoTherme-600 welds well in the horizontal position. Soft arc, smooth seam surface. It still retains great hardness at high temperatures, even at red heat, and recovers its original hardness after cooling.

Applications:

LoTherme-600 is the hardest of the cobalt-containing alloys and is used mainly for severe friction wear, erosion and corrosion. It is very resistant to sliding stressing metal-to-metal, and is therefore recommended for pump bushes, screw conveyors, wear rings, guide rails, cutters, rolls.

Weld Metal Hardness :

At Room Temperature : 45-55 RC

At 600°C : 43-48 RC

Welding Technique:

Re-dry the electrodes at 250°C for one hour before use. Clean the weld zone of rust, scale and grease. Bigger work pieces are preheated to about 300°C. Keep the amperage as low as possible, so as to fuse the parent metal as little as possible. Guide the electrode vertically, keeping the arc short. Weave only slightly. Cool slowly in an oven or under asbestos. Machinable only by grinding.

Current Conditions : DC(+)

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	150-190	120-160	80-120	60-90
(Amps)				