



# LoTHERME



## LoTherme - 604

**Unique graphite based low heat electrode for hard facing overlays on machine parts and components subject to high abrasion and moderate impact.**

### **Characteristics :**

LoTherme-604 yields hard and tough deposits, which have excellent resistance to abrasion in combination with friction, moderate impact.

### **Applications:**

LoTherme-604 is ideally suited for surfacing machine parts subject to high stress grinding abrasion as also grouping abrasion on carbon steels, manganese steels, malleable iron and air hardenable alloy steels. Typical applications for abrasion resistance include excavator teeth, ploughshares, cultivators, impellers, excavator buckets, bucket teeth, cams, fan blades, exhaust blades, scraper bars, dredger buckets and oil expeller worms. It is also well suited for coal crushing applications such as mill hammers, pulverizers and cement grinder rings.

**Weld Metal Hardness** : 56 - 62 RC

### **Welding Technique :**

Re-dry the electrodes at 200°C for one hour before use. Clean the weld area. Use short arc and avoid weaving of the electrode. While surfacing medium and high carbon steels use LoTherme-352 for buffer layers to avoid chances of cracking. Do not use more than two layers of LoTherme-604 at a time. For a heavy build-up, deposit a cushion layer of LoTherme-352 or LoTherme 607 followed by two layers of LoTherme-604.

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

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	165-190	120-160	90-120	70-90
(Amps)				