



# LOTHERME



## LoTherme - 606

**Co-Cr-W-alloy of Cobalt Grade 6 hard-facing to resisting impact and wear.**

### **Characteristics :**

LoTherme-606 welds well in the horizontal position. Soft arc, smooth seam surface. High resistance to impact, corrosion and hardness at elevated temperature under alternating temperatures stressing.

### **Applications:**

LoTherme-606 is used primarily on work-pieces exposed to high alternating temperatures and corrosion. Specific applications: valves and valve seats, sealing surfaces, hot shear blades, hot pressing tools, forging de-burrers, wire mill rolls and beaters for coke combustion.

### **Weld Metal Hardness :**

At Room Temperature : 32-40 RC

At 600°C : 30-35 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 with tungsten carbide tools.

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

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