



LOTHERME



LoTherme - 607

Versatile low heat input welding and surfacing electrode producing a weld metal highly resistant to cracking, heavy impact, metal-to metal wear and deformation, with rapid work hardening.

Characteristics :

LoTherme-607 is characterised by excellent performance in all conventional positions, soft and stable arc which is easy to strike and re-strike, good slag detachability and well rippled, uniform weld beads. The electrode produces a unique weld metal chemistry and set of physical and mechanical properties which are highly favorable for obtaining crack free weld deposits having outstanding resistance to heavy impact, metal-to-metal wear and plastic deformation.

Applications:

LoTherme-607 is ideally suited for use on austenitic manganese steels. Typical applications include surfacing and building up of broken or worn out 14% manganese steel parts such as jaw and roll crushers, crusher hammers, excavator bucket teeth and lips, dredger buckets, dipper teeth, rail road trucks, frogs and switches and similar machine parts and components subject to heavy impact and high stresses.

Weld Metal Hardness :

As Welded : 160-200 BHN
Work hardens under impact up to : 43-53 RC

Welding Technique :

Re-dry electrodes at 250°C for one hour. Clean the weld area. Use low current, short arc, short and stringer beads. For joining or resurfacing of austenitic manganese steel, ensure that the inter-pass temperature does not exceed 100°C, by keeping the object submerged partially in a tank full of running water.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	160-190	110-150	80-120	50-80