



LoTHERME



LoTherme - 608

Versatile low heat input electrode for hard-facing and overlay applications on high speed steels and tool steels.

Characteristics :

LoTherme-608 is a versatile electrode for surfacing, inlay, overlay and hardfacing of a variety of machine tools and components for prolonged service life. The weld deposits are highly resistant to wear and retain hardness and toughness up to 600°C. This special feature enables the weld metal to retain its cutting edge and hardness even at elevated temperatures. Use of LoTherme-457 may be necessary as buffer layer on tool steels.

Applications:

LoTherme-608 has been specially designed for surfacing cutting tools, dies, punches, bamboo chipper knives, paper cutting knives, shearing blades, boring tools, and large number of other machine tools requiring high speed steel type deposit of appropriate hardness.

Weld Metal Hardness : 56 - 60 RC

Welding Technique :

Keep the electrodes dry. In case of moisture pick-up, re-dry at 250°C for one hour before use. Clean the weld area free of any surface-contamination. Pre-heating of hardenable steels, complicated parts and heavy sections at 200-300°C may be necessary depending upon the size and type of the job.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
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Dia x Length

Current Range	160-200	140-170	90-120	60-90
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(Amps)