



LoTHERME



LoTherme - 611

Low heat input, versatile, hard-facing electrode having excellent resistance to abrasion accompanied by mild impact.

Characteristics :

LoTherme-611 is a versatile low heat input electrode producing a weld metal having exceptional resistance to heavy abrasion in combination with high compressive load and moderate impact even at temperatures up to 500°C. Soft and stable arc, which is easy to strike and restrike, easily detachable slag and smooth, regular weld bead are some of the pleasant features associated with the electrode.

Applications:

LoTherme-611 is ideally suited for hardfacing parts and components subject to heavy abrasion, erosion, metal-to-metal wear and moderately heavy impact. Typical applications include air rings, conveyor screws, dredger buckets, shovels, impellers, mill hammers, mixer blades, muller ploughs, dipper teeth, I.D. fans, etc. in steel mills, construction and earth moving machinery, power plants and cement industry.

Weld Metal Hardness : 55 - 58 RC

Welding Technique:

Re-dry electrode at 250°C for one hour before use. Clean weld surface free of all surface contamination. Use short arc and stringer bead technique.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-190	130-160	90-120	60-80