



# LOTHERME



## LoTherme - 616

Electrode for resisting high abrasion wear with moderate impact at 450°C.

### Characteristics :

LoTherme-616 is a high Niobium-Chromium Carbide alloy specially designed to resist high stress grinding abrasion wear with moderate impact, even at elevated temperature of 450°C. The deposit will exhibit surface relief checks.

### Applications:

It is suitable for welding of conveyor screws, VRM tyres, Coke chutes, coal mill exhaust fan blades, table liners, screens, oils expeller screws, etc.

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

### Welding Technique :

For best result, re-dry the electrodes at about 200-250°C for 1 hour before use. Remove all the damaged and fatigued metal and clean weld area. Use short arc and stringer bead technique. For High Carbon Steels use preheat up to 300°C. For austenitic manganese steels do not allow the temperature of parts to exceed 150°C and use LoTherme-457 as cushioning layers. Slow cool after welding.

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

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

Current Range	170-220	130-160	110-140	70-90
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(Amps)