



LoTHERME



LoTherme - 617

Low heat input, hardfacing electrode having excellent resistance to high stress abrasion, severe erosion at moderate temperature.

Characteristics :

- A versatile electrode producing a weld metal having exceptional resistance to wear from combined abrasion, erosion and moderate impact.
- Soft and stable arc which is easy to strike and re-strike.
- Electrode deposits high rate of weld metal with little slag.
- Thick single pass deposits give high yield.

Applications:

LoTherme-617 is ideally suited for hardfacing machine parts and components subject to combination of heavy abrasion, erosion, and moderate impact. Typical applications include surfacing carbon steels, austenitic manganese steels like drag line bucket walls, scraper blades, crushing blades, crushing hammers, conveyor chains, etc.

Weld Metal Hardness : 57 - 62 RC

Welding Technique :

For best result, re-dry the electrodes at about 200-250°C for 1 hour before use. Remove all damaged and fatigued metal before deposition. Use short arc and stringer bead technique. One pass overlay is normally recommended. If more build-up is required, use cushion layer of LoTherme-602 for steels, LoTherme-457 for 14% manganese steels.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	150-180	120-150	80-110	70-90