



LOTHERME



LoTherme - 619

Low heat input hard-facing electrode for reconditioning of worn-out MM steel and Gr. 90A points and crossings for use in high traffic density routes.

Characteristics :

LoTherme-619 has been formulated to produce strong, tough, easy work hardening and highly abrasion resistible austenitic 15Cr-15Mn-2Ni weld metal. The electrode possesses pleasing operating characteristics and produces smooth, well-rippled weld beads, with easy slag detachability.

Applications:

LoTherme-619 is ideally suited for welding high manganese steel such as rail crossings, Bulletproof steel plates, Crushing blades, Crushing hammers etc.

Weld Metal Hardness :

As Welded : 230-260 BHN

Work hardens under impact up to : 400-470 BHN

Welding Technique :

Keep the electrode dry. In case of moisture pick up, re-dry the electrode at 250°C for one hour. Clean the weld area thoroughly free of any foreign matter, Use low current, short arc and stringer beads,

Current Conditions : DC(+) / AC

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

Current Range	160-200	140-180	100-140	70-90
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(Amps)