



LOTHERME



LoTherme - 621

Specially designed Electrodes produces cobalt base grade 21 weld metal with Mo for Impact, Pressure & Abrasion at elevated temperature.

Characteristics :

LoTherme-621 has excellent welding properties and a homogeneous, finely rippled bead due to spray arc. Very easy slag removal.

Applications:

LoTherme-621 is used for crack resistant hardfacing on parts subject to a combination of impact, pressure, abrasion, corrosion and high temperatures up to 900°C, such as running and sealing faces on gas, water, steam and acid fittings and pumps, valve seats and cones for combustion engines, working parts in gas and power plants, hot working tools with changing thermal load. Excellent gliding characteristics, good polishability and toughness, highly work hardening nonmagnetic, machinable with cutting tools.

Weld Metal Hardness :

At Room Temperature : 250-300 BHN

At 600°C : 220-280 BHN

Work hardens under impact up to : 45 RC

Welding Technique :

Ensure that the electrodes are dry. In case of moisture pick-up, re-dry the electrodes at 300°C for 2 hours before use. Clean weld area and preheat the base material. Hold electrode vertically and with a short arc and lowest possible amperage. Ensure slow cooling.

Current Conditions : DC(+) / AC

Size (mm)	5x350	4x350	3.15x350	2.5x350
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Dia x Length				
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Current Range	160-200	120-160	80-120	60-90
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(Amps)				
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