



LoTHERME



LoTherme - 625

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 35 GMT.

Characteristics :

LoTherme-625 is characterized by producing easy work hardening and highly wear resistible austenitic 17Cr - 15Mn - 3Ni weld metal. The electrode possesses pleasing operating characteristics and produces smooth, well-rippled weld beads.

Applications:

LoTherme-625 is ideally suited for welding high manganese steel such as rail crossings and points, jaw and roll crushers, crusher hammers, crushing blades, etc.

Weld Metal Hardness :

As Welded : 200-300 BHN

Work hardens under impact up to : 400-470 BHN

Welding Technique :

Keep the electrode dry. In case of moisture pick up, re-dry 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				
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Current Range	200-250	160-190	130-160	100-130
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(Amps)				
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