LOTHERME

Estd. 1966 D&H sécheron Complete Welding Support

LoTherme - 601

Low heat input touch-weld electrode for machinable overlays on all ferrous metals Deposit in flame hardenable.

Characteristics :

LoTherme-601 is characterized by a soft and stable arc, which is easy to strike and restrike, smooth, crack free welds, good slag detachability.

The deposited weld metal has a high degree of toughness, excellent resistance to rolling and sliding friction and heavy impact loads.

Applications:

LoTherme-601 is a versatile electrode for hardfacing, overlay and inlay applications on all ferrous metals, components, machine parts requiring moderate hardness in combination with good machinability, such as tractor sprockets, gears, shafts, axles, pinion teeth, concrete and pan mixer blades, ropeway and tram car rails, and wheels, points and crossing, crane wheels, ropeway trolley wheels.

Weld Metal Hardness : 240 - 300 BHN

Welding Technique :

Clean the weld area. Use low current and a short arc length. Avoid weaving of the electrode. While surfacing on medium and high carbon steels, use LoTherme-352 for buffer layers in order to avoid chances of cracking. For surfacing on heavy sections and materials high in carbon, pre-heating of the part may be necessary.

Current Conditions : DC(+)

Size (mm) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	150-250	130-160	95-120	60-90