

EutecTrode 27

Manual Metal Arc Electrode For Buffering Layer For Problematic / Contaminated Cast Iron

DESCRIPTION

EutecTrode27 is an iron core electrode with a flux coating designed to produce 'arc spray' transfer type. It is excellent for bonding welds on parts highly degraded by oxidation, corrosion and thermal fatigue. It can be used for casting repairs and wearfacing cast iron parts. It removes the S and P excess on cast iron surfaces. The electrode produces a hard and dense iron carbide type deposit with excellent resistance to abrasion, pressure and high temperatures in a single pass.

Product Details

High arc force powers through contaminants to clean and seal metal surfaces. Good for pre-welding preparation on unknown and low-grade cast iron repairs. Non-machinable.

APPLICATIONS:

For bonding layer on old, burnt or poorly weldable cast iron. Another electrode (Castolin 224, Castolin 242, etc.) should be used to finish the joint.

Hard facing on cast iron parts subject to abrasion and frictional wear at high temperature (slides and guides in the steel industry, as well as drawing radii or brakes in the die-making industry).

PROCEDURE FOR USE:

Preparation: Ensure that areas to be welded are free from surface defects, sand and scale. Damaged and fatigued base materials should be removed using ExoTrode

Preheating: Preheating is not generally necessary, it is recommended that components are kept at ambient temperatures, and allowing each pass to cool before commencing subsequent welds.

Welding: Employ a near vertical electrode angle and maintain an arc length as short as possible. Deposit by applying stringer beads ensuring that the depth of deposit is as thin as possible,

this is to avoid local overheating and minimize dilution. Limit each weld to between 2-5 cm, (1- "2") and insure that the workpiece is kept as cool as possible throughout the welding operation.

For joining applications and the repair of cracks complete the joint by using Xuper Castolin 224, Castolin 242.

The machinability of EutecTrode 27 is poor and therefore may, only be effectively prepared by grinding.

TECHNICAL DATA

Typical Hardness : 54 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.5mm	50-80
3.2mm	60-120
4.0mm	90-130

Note: For optimum result use the lowest amperage practical