

EutecTrode 2

Manual Metal Arc Electrode For Protective Coatings Against Impact, Abrasion and Pressure.

DESCRIPTION

The weld deposit of EutecTrode 2 consists of a hard, fine grained structure containing Cr, Mn and Mo, producing excellent resistance to abrasion, impact and pressure combinations suitable for protective overlays on steels including plain carbon steel, carbon-manganese steels and low alloy steels.

Product Details

- Deposits exhibit good cracking resistance
- If deposits are not annealed, machining is only possible by grinding
- The deposit hardness can be further optimized by heat treatment or nitriding
- Easy slag removal
- Deposits are heat treatable

APPLICATIONS

For dragline, bucket teeth, crusher hammers, stamping dies, excavator parts, tractor treads.

PROCEDURE FOR USE

Preparation: Prepare surface areas to be welded by removing all contaminants, oxides etc., also damaged and fatigued base material using ChamferTrode04. It is also recommended that sharp corners and edges are prepared to form a radius to minimize dilution effects.

Preheating: Depends on the steel's Carbon Equivalent and the workpiece size, thickness and the geometry. Castolin Eutectic recommends:

CE < 0.2 : preheating not essential.

CE 0.2-0.4 : preheating

200-100°C CE 0.4-0.8 : preheating

350-200°C

Note that 12-14% Mn steels should never be preheated and the workpiece temperature during welding should be kept below 250°C

Welding:

Maintain a near vertical electrode angle and employ a short arc length, deposit either as stringer beads. When welding in the vertical position maintain the electrode at right angles to the base material plane.

Where large depth build-up applications exist use CastoDur N 102. For intermediate layers to austenitic manganese steels use XHD 646.

Parts which have been preheated should be allowed to cool slowly down to room temperature.

TECHNICAL DATA

Typical Hardness : 55-62 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.5mm	80-130
3.2mm	100-160
4.0mm	160-190

Note: For optimum result use the lowest amperage practical