

EutecTrode 400

A Versatile Electrode With Excellent Resistance To Impact

DESCRIPTION

A ferrous base electrode with additions of Ni, Mn & other elements to improve welding properties. deal Cushion layer before hardfacing on Mn steel, low carbon steel, low alloy steel.

Product Details

- Tough overlay on manganese steel and alloy steel.
- For severe impact, shock and hammering applications.
- Frigid arc coating for lowest possible amperage.
- Work hardens in service.

APPLICATIONS:

Crusher hammer, wobblers, frogs, sprockets, bucket teeth, wear parts, shovel track pads, under carriage components, scraper blades.

PROCEDURE FOR USE

Work hardened: 35-45 HRC Clean weld area. Use Eutec- ExoTrode electrode to remove damaged metal. Do not preheat manganese steels. Maintain a short to medium arc length. On Mn steel keep bead length 75-100 mm at a time. Inter-pass temperature should 0 be maintained below 150°C for Mn steel by following back-step technique . Skip welding is recommended on large parts. Peening while hot reduces residual stresses. Cool slowly.

TECHNICAL DATA

Typical Hardness

As deposited: 85-95 HRB

Work hardened: 35-45 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	90-130
4.0mm	120-160
5.0mm	150-210

Note: For optimum result use the lowest amperage practical