

EutecTrode 700

Manual Metal Arc Electrode For Combined Abrasion, Moderate Impact And Metal-Metal Friction

DESCRIPTION

High metal recovery manual electrode (130%) developed for wearfacing against abrasion, moderate impact and metal-metal friction.

Product Details

- Very stable arc.
- Easy removal slag.
- Excellent weldability even at low amperage.
- Resistant against wear under high pressure, impacts and abrasion.
- Smooth deposit to favor gliding of abrasives.
- Very soft fusion.

APPLICATIONS

For applications where resistance to intense abrasion moderate impact and metal-metal friction is required on work parts like for example:

- Buckets of dredges
- Hammers of crushers
- Excavator teeth
- Concrete Walls
- Rotors of pumps
- Chain conveyors
- Wear Plates

PROCEDURE FOR USE

Preparation

For best results, remove contamination, cracks and worn metal from weld area. This may be achieved by using ExoTrode.

Preheating: Temperature depends on steel Carbon Equivalent (CE), work piece dimensions, the thickness and geometry. Castolin Eutectic suggests:

CE < 0.2 : preheating not essential.

CE 0.2-0.4: preheating 100-200°C

CE 0.4-0.8: preheating 200-350°C

TECHNICAL DATA

Work hardened: 58-65 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	90-120
4.0mm	130-160
5.0mm	150-190

Note: For optimum result use the lowest amperage practical