

ChromCarb N 6006

Unique Chromium-Carbide Bearing Electrode With Superior Abrasion And Impact Properties

DESCRIPTION

ChromCarb N6006 is an electrode for the overlay and protection of carbon, alloy and manganese steels. A high chromium carbide content makes it especially favorable against coarse particle abrasion, moderate gouging impact and mild corrosion in any number of service conditions.

Product Details

- For use on most carbon, low-alloy and air. manganese steels
- Resistant to coarse particle abrasion with moderate impact
- Provides dense, smooth, easy to clean deposits

APPLICATIONS:

Muller tires ,Anvils, Dredger parts Bucket arms, Pug mill paddles Hot pressing dies and hot hardness dies, etc.

PROCEDURE FOR USE

Preparation: Clean weld area of scale and/or oxide. A nominal preheat of 150°F is advised if part is below 409°F or over 1" thick. For higher carbon steels higher preheats will be needed. Check the Reference Section for information regarding specific preheating levels for specific steel grades.

Note: *Do not preheat Hadfield manganese steel castings above 400°F as this will cause time-temperature embrittlement.*

Technique: For base metals with high hardenability a buffer layer is highly recommended prior to application of ChromCarb N6006. For Manganese steels, use EutecTrode 40; for air-hardenable steels, use EutecTrode 680 and for cast irons, Xuper 2233N. Only one pass of ChromCarb N6006 should be used on cast irons.

Maintain a medium arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2 times the electrode diameter) is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit wear properties. Back whip craters to reduce crater-cracking tendencies.

Post-welding: Allow parts to slow cool in still air. High carbon steels and air hardenable steels should be covered with a heat-retardant blanket.

TECHNICAL DATA

Work hardened: 55-60HRC

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