

EutecTrode EC 6611

High Strength Electrode For Joining And Repair Of Cast Steels And Hsla Steels

DESCRIPTION:

Joining, build-up and repair of new, worn-out or cracked steel structures, machinery components and other heavy duty equipment & welding of cast steels, fabrication of micro alloyed and H.S.L.A. steels including automotive applications. Specially suited for repair of forging equipment like columns, sow blocks

Product Details

Non-hygroscopic flux coating. Strong, stable arc. Self releasing slag.

No temper embrittlement of weld deposit.

APPLICATIONS:

Hammer bases, columns, rams, sow blocks, keyways, kiln shell.

PROCEDURE FOR USE

Clean weld area. Remove fatigued or cracked metal. Bevel all edges 60°. For heavy sections, pre-heat 250° - 300° C. Weld with short arc gap and electrode tilted 10° in travel direction. Use 'stringer bead' deposition, chip slag between passes and peen weld beads. After completion, retard cooling by covering with sand, asbestos etc. For large assemblies and for forging equipment, stress relieving at 550°C-600°C for one hour per inch job thickness recommended.

TECHNICAL DATA

Tensile Strength: 660 N/mm² (96,000 psi).

Hardness - 15-25 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.15mm	90-130
4.00mm	120-160
5.00mm	150-190

Note: For optimum result use the lowest amperage practical