

EutecTrode EC 6622

Joining and Build-up Electrode

DESCRIPTION

EutecTrode EC 6622 is a high-strength electrode specially developed for surfacing and joining of dissimilar steels and low alloy components. It offers excellent protection against corrosion, particularly in sugar and steel industry environments, and provides smooth, machinable welds with high tensile strength.

Product Details

- Excellent resistance to corrosion
- Welds can be machined to a high polish finish
- Low friction surface
- Multi-pass friendly – crack-free even with
- thick build-ups
- Ideal for low to medium carbon steel and low

APPLICATIONS

- Sugar mill rolls -Crusher roll journals
- Bearing areas of shafts
- Dissimilar steel joints

PROCEDURE FOR USE

Preparation: Clean the weld area. Remove fatigued or cracked metal.

Beveling:For thick sections, bevel to 60° V – groove.

Welding Technique:

- Uses short arc with short beads.
- Remove slag between passes.
- Apply staggered welding sequence to prevent overheating.

Build-Up: Suitable for multiple layers without cracking.

TECHNICAL DATA

Tensile Strength 520 N/mm² (75,000 psi)

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.50mm	40 – 70
3.20mm	70 – 100
4.00mm	100 – 140

Note: For optimum result use the lowest amperage practical