

EutecDur N 6070

Manual Metal Arc Electrode For Protective Maintenance Coatings

DESCRIPTION

A high efficiency complex carbide alloy electrode containing controlled percentages of hard constituents producing, extremely hard deposits resistant up to 650°C.

This alloy produces a deposit of fine metallurgical structure by Dispersion Hardening, which gives excellent resistance to abrasion and erosion by both fine and coarse mineral particles, particularly the former, from ambient to elevated temperature. Additionally, its superior oxidation resistance, very effectively hinders the phenomenon of accelerate abrasive wear which often occurs in very high temperature applications. Excellent metal recovery rates are obtained. The arc characteristics are of the «spray type» producing smooth, ripple-free deposits.

Product Details

- Exceptional abrasion resistance
- Extremely hard deposits
- Fine metallurgical structure
- Contains ultra-hard complex carbides
- Very stable arc
- Minimal slag residues
- For use with AC or DC power source

APPLICATIONS

For protecting components against abrasion and erosion, especially where both fine and coarse grain mineral particles are present. Suitable for a wide range of steels including medium carbon steel, low alloy steels and authenticate manganese steels. For extrusion screws, hoppers and chutes, bulldozer blades, scrapers.

PROCEDURE FOR USE

Preparation: Remove all damaged and fatigued base material and where possible remove sharp corners from areas to be welded by using ExoTrode.

Welding: Select lowest possible amperage setting from the recommended range when depositing direct to the base material.

EutecTrode 690X may be used as initial or intermediate layers especially on large or heavy build-up applications.

For applications where impact and pressure is present deposit into pre-prepared grooves at a pitch not less than the width of the groove (two layers should be deposited into the grooves).

Maintain an arc length equal to the electrode diameter and a near vertical electrode angle. Limit each deposit length between 100-50 mm and employ a balanced welding technique.

TECHNICAL DATA

Typical Hardness 68-70 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.20mm	135-165
4.00mm	185-215

Note: For optimum result use the lowest amperage practical