

Xuper Abratec 6088

Manual Metal Arc Electrode For Wear Resistant Coatings

DESCRIPTION

Thanks to high density and good distribution of hard DIAMAX particles in a hard nickel-based matrix, the deposit obtained with Xuper AbraTec 6088 is highly resistant to abrasion, erosion and to corrosion at high temperatures.

Product Details

This electrode welds at a low current which results in very little dilution as well as minimal deformation of the base metal including those of stainless steels and nickel alloys.

Optimal wear resistance is reached with a single layer deposit.

APPLICATIONS

Stamping, pressing, drawing and cutting tools; machining steels; hot and cold trimming tools; chisels, forging tools; clutch forks, valves, cams, grabs, mixer blades, feed screws.

PROCEDURE FOR USE

Preparation

Remove all damaged and fatigued weld metal from areas to be welded and remove sharp edges. Where compression or medium impact factors exist deposit into prepared grooves. Prepare grooves 5-3 mm wide, 6 mm in depth using ExoTrobe and deposit two passes using Xuper AbraTec 6088.

Preheating

Preheating depends on the steel's Carbon Equivalent and the workpiece size, thickness and the geometry. Castolin Eutectic recommends: CE < 0.2: preheating not essential.

CE 0.2- 0.4: preheating 100-200°C CE 0.4- 0.8: preheating 200-350°C

Note that 12-14% Mn steels should never be preheated and that the workpiece temperature during welding should be kept below 250°C.

Welding

Maintain a short arc length, and hold a near vertical electrode angle, in the direction of travel. For heavy deposits, intermediate layers using XHD 646 is recommended.

Depending upon thickness and alloy content of the component, slow cooling after welding may be advisable.

TECHNICAL DATA

Typical Hardness

Hardness Ni base matrix: 56 HRC

Hardness Diamax (HV10): up to 2300

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
5.0mm	100-140

Note: For optimum result use the lowest amperage practical