

EutecTrode XHD 6395N

Nanoalloy® Electrode For Manual Wearfacing Applications

DESCRIPTION

Eutectrode XHD 6395N is based on the science and engineering of Nanotechnology. Weld deposits have a high volume fraction of ultra-hard, complex borocarbides distributed evenly in a unique, semi-amorphous iron alloy matrix. Easy to use and welder-friendly, 6395N offers a higher caliber of abrasion resistance reinforced by a tough, ductile matrix for added impact resistance. 6395N outperforms chromium and complex carbides by up to 6395 !%40N's wear resistance is equal to that of a 35% tungsten carbide alloy at a lower cost.

Product Details

- Unique NanoAlloy structure for unmatched abrasion and erosion resistance
- Produces tough uniform 67 HRC single and double pass weld deposits
- Wears like tungsten carbide at a fraction of the cost
- Outlasts chrome carbide and complex carbide alloys
- Ensures enhanced productivity and cost savings
- Smooth ripple-free weld surface
- High efficiency metal recovery
- Precision grind able deposits
- Stress relieving cracks
- Easy striking and re striking for anti-wear patterns
- Retains high hardness properties at elevated temperatures
- Single pass attains close to maximum hardness
- With stands thermal cycling up to 1200°F (650°C)

APPLICATIONS

Bucket Teeth/ Lips: Mining Crusher Bar: Earth Moving Shredders/Knives: Waste/Recycling Feed Screw: Pulp And Paper Roller Crusher: Iron And Steel Dredging Teeth: Construction

PROCEDURE FOR USE

PREPARATION: Remove all “old” cracked or spalled material down to a sound base. Clean any residual oxides, coatings, spatter or residue. For steels with higher alloy content or which require build-up greater than ¼” a 2-pass buffer layer of Eutectrode 680 is strongly recommended.

EutecTrode 6395N is not recommended for applications beyond a 2 pass maximum. For best results apply EutecTrode XHD 6395N with as little heat as possible, allowing parts to cool between layers.

Eutectrode XHD 6395N Should Not Be Used On Manganese/ Hadfield Steels As It Will Not Bond!

TECHNICAL DATA

Typical Hardness as deposited :67-70 HRC

Current Polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	120-150
4.0mm	150-175

Note: For optimum result use the lowest amperage practical