

EutecTrode 6450

Manual Metal Arc Electrode For Anti-Wear Coatings

DESCRIPTION

High chrome manganese alloy electrode for TeroCote protective coatings and cushion layers on carbon steels, low or high alloy steels and manganese steels.

Product Details

- Maximal resistance to impact and pressures.
- Very work-hardenable deposit.
- Excellent ac/dc weldability.
- Machinable with cutting tool.
- Can be contact welded.
- Excellent crack resistance by absorption of internal stresses.
- Amagnetic 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: Obtain a good surface by removing worn metal with ExoTrode or by mechanical means.

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

Keep a short arc, the electrode slightly sloping, possibility of contact welding. Follow welding procedures exactly.

TECHNICAL DATA

Tensile strength: 830 N/mm² (120,000 psi)

Typical Hardness

As deposited: 20-23 HRC

Work hardened: 37-42 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	100-160
4.0mm	120-180

Note: For optimum result use the lowest amperage practical