

XHD AbraTec N^{*}6710

Manual Metal Arc Electrode For Anti-Wear Protective Coatings

DESCRIPTION

High efficiency electrode for TeroCote coatings on alloyed and non-alloyed steels, austenitic steels with 12-14% manganese. Deposit with a high content of hard constituents of Nucleo-C elements, resistant to intense abrasion under pressure and moderate impact.

Product Details

- High resistance to wear from combined abrasion, pressure and impact
- High deposition speed
- Very thick single pass deposits
- Very high weld yield (250%)
- Minimal dilution with the base metal
- Virtually slag free
- Non-hygroscopic coating
- Easy striking and restriking

APPLICATIONS

Main applications For dragline buckets.

Other applications

For protective, antiwearcoatings of scraper blades and mixers, sludge pumps, hammers and crushers, conveyor chains, teeth, edges of buckets, etc.

PROCEDURE FOR USE

Preparation: Remove all damaged and fatigued metal from areas to be over layed, and remove sharp edges where compression or medium impact factors exist. Deposit into prepared grooves. Prepare grooves 3 mm to 5 mm wide, 6 mm depth, using ExoTrode, and deposit two passes using XHD 6710.

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 medium arc with electrode nearly vertical. Deposit «stringer» beads. To complete each bead travel back over the deposit by about 10 mm to fill craters before breaking the arc. As the intrinsic properties of the deposit are obtained in the first pass, one pass will be adequate for most applications. Should a thicker overlay be required, build up to required dimensions with XHD 646 finishing with EutecTrode6710XHD.

TECHNICAL DATA

Typical Hardness : 63-69 HRC

Current polarity: AC/DC (-)

DIAMETER	AMPERAGE
3.2mm	100-170
4.0mm	140-220
5.0mm	160 - 240

Note: For optimum result use the lowest amperage practical