XHD AbraTec N*6715

Manual Metal Arc Electrode For Anti-Wear Protective Coatings At High Temperatures

DESCRIPTION

High efficiency welds containing a maximum percentage of hard constituents with Nucleo- C elements which offer excellent resistance to high temperature abrasion and ero12-14% gas media. Suitable for overlaying a wide range of steels including low alloy steel and 12-14% austenitic manganese steels.

An alloy of complex carbides producing excellent abrasion resistance up to 650.C. Deposition speeds are high and arc striking is made with comparative ease, ideal for wear pattern formations. Deposits are extremely smooth with little or no ripple formation, ideal where resistance to fine mineral particles is required. No slag residues due to the complete consumption of core wire and flux coating.

Product Details

- Non-hygroscopic coating
- Positional weldability
- High metal recovery (%230)
- Low dilution with base metal
- Easy slag removal.
- Ease of arc striking and restriking
- High deposition speeds
- Very thick single pass deposit
- No slag residues
- alloy steel components

APPLICATIONS:

Main applications

For sinter plant ventilators.

Other applications

Crusher bars, agglomeration fans, blast furnace hoppers and bells, mixer screws and heads in the ceramics industry.

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 3-5 mm wide, 6 mm in depth using ExoTrode and deposit two passes using XHD 6715.

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.

Cladding and Intermediate layers. For 12-14% austenitic manganese steels apply an intermediate layer using EutecTrode 646XHD.

Welding

Maintain a short arc length, and hold a near vertical electrode angle, in the direction of travel. To complete each weld bead -travel back over the deposit approximately 10 mm and lengthen the arc. For heavy deposits, intermediate layers using EutecTrode 646XHDisrecommended.

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

TECHNICAL DATA

Typical Hardness 62-68 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