

EutecTrode XHD 6804

Manual Metal Arc Electrode For Coating High And Low Alloy Steels And Tool- Steels

DESCRIPTION

EutecTrode 6804XHD is a unique formulation and, owing to a judicious combination of carefully dosed alloy additives, this electrode offers the following properties:

Product Details

- Exceptional weldability, stable arc, perfect metal transfer
- Easy to use, smooth flow without spatters
- Good appearance with perfectly regular beads
- Solid, dense deposit, free of porosity or microcracks
- No risk of cracking with multiple pass welds
- Maximum hardness after one pass
- Retained hardness independent of thermal cycles up to 500°C
- Excellent resistance to metal/metal friction up to 500°C
- Extensive overlays possible without any risk of overheating
- Bonding layer normally not necessary
- Excellent wetting
- Slag readily removed
- Efficiency yield 130%
- Contact heat quickly removed
- Very tough and creep resistant
- Very good resistance to oxidation.

APPLICATIONS

Principal applications

Draw plates, chucks, plungers for hot-extrusion. Other uses Spinning rotors for glass-wool production. Stamping and trimming dies. Kiln parts. Pump shafts. Industries involved in high temperature metal processing Extrusion of hollow profiles. Metal drawing. Forming. Cropping. Industries involved in cold metal processing Automobiles. Cutting of thin sections. Chemicals. Foundries. Forming. Textiles. Steel. Power stations. Stamping. Petrochemicals. Rolling mills.

PROCEDURE FOR USE

Preparation: Remove worn metal using ExoTrode or prepare by mechanical means to obtain a sound surface.

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

Welding: Electrode almost vertical, short arc. Before breaking the arc to halt welding, draw back the electrode until the weld crater is filled.

TECHNICAL DATA

Typical Hardness : 48-50 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.5mm	60-80
3.2mm	180-140
4.0mm	120-180

Note: For optimum result use the lowest amperage practical