

Xuper XHD 6868

For Joining, Cladding, Disimilar And Galvanized Steels

DESCRIPTION

High-performance alloyed electrode designed for industrial maintenance welding applications. It features a specially formulated flux coating and alloy core wire, resulting in a deposit with a grain-refined, binary-phased microstructure that maintains mechanical properties despite variable dilution effects.

Product Details

- Superior tensile strength and high crack resistance Compatible with most types of steels.
- All positional capability and DC/AC performance to prevent magnetic arc blow effects.
- Electrode flux coating resists overheating, allowing for easy contact weldability
- Produces clean, uniform weld beads with minimal spatter

APPLICATIONS

Maximum safety margin repairs of cracks in castings, machine housings, frames, chassis, springs, etc.

Joining dissimilar or unknown grades of steel
Machinable build-up and overlays to resist wear by friction, impact, or pressure on gears, shafts, bearings, etc.

Cushion layer for E+C TeroCote alloys

can be used to join extension pieces to electric polls, signal post, support and fixtures to protect against corrosion in the open air.

PROCEDURE FOR USE

Preparation: According to the thickness of the part, chamfer in a «V», «U» or an «X» to 80-90° angle with ExoTrode or grind. Remove all sharp corners and cracks.

Preheating:

CE < 0.2: preheating not essential

CE 0.2 - 0.4: preheating 100-200°C

CE 0.4 - 0.8: preheating 200-350°C

Do not preheat austenitic-manganese steels; keep them cool.

Welding: Maintain a medium arc length with the electrode held near vertical to the direction of travel. Weaving should be limited to 2 x electrode diameter. Electrode contact welding can be used in the flat position and in fillet joints. retardant material to help with slow cooling.

TECHNICAL DATA

Tensile strength: 803 N/mm² (116,000 psi)

Typical Hardness

As deposited: 24-26 HRC

Work hardened: 35-37 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.0mm	75-90
2.5mm	90-120
3.2mm	120-170
4.0mm	150-240

Note: For optimum result use the lowest amperage practical