

EutecTrode 7020

All-Position, Tubular Hardfacing Electrode Combats Severe Abrasion and Medium Impact

DESCRIPTION

EutecTrode 7020 is a highly alloyed composition suitable for severe abrasion with medium impact and maintains deposit hardness up to 1000°F (538°C). This all-position, tubular electrode has a high deposition rate for increased efficiency, productivity, coverage and usability. When used at low amperage, dilution is minimized and the key wear resistant properties are maintained. EutecTrode 7020 possesses built-in moisture resistance.

Product Details

- Designed for maximum efficiency and productivity
- Maintains high temperature hardness to 1000°F (538°C)
- Slag-free weld deposits
- Low operating current and low heat input

APPLICATIONS

- Pug Mill Augers: Raw material Processing
- Muller Tires: Iron and Steel Works
- Dozer Teeth: Various
- Sheepsfoot Tampers: Construction
- Cage Crushers: Fertilizer Industry
- Asphalt Mixer Paddles: Civil Eng./ Construction
- Fan Blades: Various

PROCEDURE FOR USE:

PREPARATION: Clean weld area of scale and/or oxide. A nominal preheat of 150°F (65.5°C) is advised if the part is below 40°F (4°C) or over 1" thick. For higher carbon steels higher preheats will be needed.

Note: Do not preheat Hadfield manganese steel castings above 400°F (204°C) as this will cause time-temperature embrittlement.

TECHNIQUE: Maintain a medium-to-short arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2x the elec- trode diameter) is not advised as wide beads can cause excessive base metal overheating and de- grade the weld deposit wear properties. Back whip craters to reduce crater-cracking tendencies.

Do not deposit more than two layers.

POST WELDING: Allow parts to slow cool in still air. High carbon steels and air hardenable steels should be covered with a heat-retardant blanket.

TECHNICAL DATA

Typical Hardness : 55 - 60 HRC

Carbide Hardness: 1100 - 1200 VPN (M7C3)

Carbide Content: Medium

Current Polarity: AC/DC (+/-)

DIAMETER	AMPERAGE
6.4mm	85-135
9.5mm	130-190
12.7mm	200-430

Note: For optimum result use the lowest amperage practical