

Eutectrode 7030

All-Position, Tubular Hardfacing Electrode Combats Fine Partical Abrasion, 2-Body Abrasion And Light Impact

DESCRIPTION

EutecTrode 7030 is specifically formulated to resist fine particle erosion, -2body abrasion and light impact while maintaining 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 7030 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

- Ripper Shanks: Quarrying
- Impeller Bars: Mining/Quarrying
- Stripper Bars: Quarrying
- Grizzly Bars: Cement Works
- Drag Chain Links: Mining
- Cement Chutes: Cement Works
- Clinker Belt Links: Cement Works
- Skip Car Lips: Deep Mining
- Discharge Chutes: Cement/Quarrying
- Cone Crusher Rolls: Quarrying
- 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-tem-perature 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 electrode diameter) is not advised as wide beads can cause excessive base metal overheating and degrade 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 VHN (M7C3)

Carbide Content: Medium to high

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