

EutecTrode 7040

All-Position, Tubular Hardfacing Electrode Combats Severe Abrasion And High Temperature Erosion And Medium Impact

DESCRIPTION

EutecTrode 7040 is formulated to resist severe abrasion and high temperature erosion up to 1500°F (815.5°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 7040 possesses built-in moisture resistance.

Product Details

- Designed for maximum efficiency and productivity
- Maintains high temperature hardness to 1500°F (815.5°C)
- Slag-free weld deposits
- Low operating current and low heat input

APPLICATIONS

- Ash Conveyor Links :Various
- Feeder Screws: Various
- Rotor & Impeller Bars: Various
- Dust Collector Fans: Cement Works
- Ash Conveyor Elbows: Various
- Sintering Plant Augers :Iron/Steel Works
- Kiln Flights: Cement Works
- 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 heat 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 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

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