EutecDur N 9080

Manual Metal Arc Electrode For Anti-Wear Protective Coatings On Hot Working Tools

DESCRIPTION

EutecDur N 9080 is a cobalt-based electrode for use on medium-carbon, hardening and air-hardening, alloy and manganese steels, as well as nickel alloys.

Product Details

- Excellent resistance to thermal cycling.
- Superior resistance to heat and scaling up to 1000.C.
- Good creep resistance, no structural modification.
- Low friction coefficient for metal/metal sliding properties.
- Work-hardens up to 60% higher than as welded.
- Ductile deposit resistant to tempering.
- High resistance to chemical corrosion.
- High crack resistance.
- Easily machinable by normal cutting tools.
- Weldable in all positions.

APPLICATIONS:

The numerous properties of EutecDur N 9080 open a large range of possible applications. This electrode should be used particularly where workpieces are submitted to various wear phenomena. It is especially suited for protective coatings on hot working tools like forging and trimming tools, wire drawing dies, shear blades tongs, plungers, etc.

- Application areas where strong resistance to wear and corrosion are needed like, Extrusion screws, press and drawing tools, sealing surfaces and valves seats, slide valves, etc.
- The easy machinability of the deposit is an advantage when rebuilding such workpieces.

PROCEDURE FOR USE

Preparation

Remove any worn metal with ExoTrode. Clean the surfaces.

Intermediate layer (preventive coating)

Depending on the base metal, it is advisable in certain service conditions to deposit an intermediate layer. Use Xuper NucleoTec 2222 or Xuper 686 For manganese steels use XHD646-, and for stainless steels, CastInox D.

- **Build-up**

Build up on medium carbon and air-hardening steels with EutecDur N 6200 or Castolin Xuper 686 on manganese steels with XHD646- and on stainless steels with CastInox D.

Welding

Keep the electrode almost vertical, with a short arc. Procedure B is the most advisable. Remove any slag before proceeding with a second pass.

TECHNICAL DATA

Typical Hardness

As deposited: 32-34 HRC

Work hardened: 48-50 HRC

Temperature : 1000.C.

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	70-120
4.0mm	90-150

Note: For optimum result use the lowest amperage practical