

EutecDur N 9120

Manual Metal Arc Electrode For Cobalt Based Wear Resistant Coatings

DESCRIPTION

EutecDur N 9120 shows a fine grain microstructure. It contains a percentage of Chromium, Tungsten and Carbon which falls between those of the other two alloys. CastoDur N 9120 shows a relative resistance with increased deposit hardness.

Product Details

- Exceptional resistance to heat giving high hot hardness values.
- Good all-round resistance to wear.
- Good arc characteristics.
- Versatility: use with AC or DC (electrode positive or negative).
- Dense deposit with excellent bead formation.

APPLICATIONS

Hot pressing dies and hot hardness dies, etc.

PROCEDURE FOR USE

Preparation: Ensure all areas to be welded are free from contaminants and where possible radius all sharp corners and edges.

Preheating: Preheating will depend upon type, size and mass of base material, it is essential that complexed shaped components. High carbon equivalent steels and low alloy steels be preheated, cast Iron components will usually require a thorough even temperature throughout the mass. Slow even heating is strongly recommended in order to reduce both distortion effects and cracking tendencies.

Welding: Hold a near vertical electrode angle and maintain as short an arc length as possible. Deposit as stringer beads ensuring sufficient overlap between

each weld in order to minimise weld metal dilution and the risk of slag entrapment, avoid weaving. Ensure that each weld deposit is thoroughly cleaned (use a stainless steel wire brush) free from slag, etc., prior to depositing a further weld. Welds should be made in a continuous manner using

the largest diameter of electrode as possible for overlay applications, for building up edge Applications use smaller diameter electrodes and ensure that sharp edges and corners have been removed.

When breaking the arc increase the speed of travel in order to reduce the size of the weld crater and clean thoroughly prior to commencing a further deposit.

It is recommended that components which have been welded are cooled slowly down to room temperature, in all cases avoid rapid and irregular cooling.

TECHNICAL DATA

Typical Hardness 48-52 HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	70-120
4.0mm	100-150

Note: For optimum result use the lowest amperage practical