

EutecTrode 670

A High Alloy Content Electrode For Welding Steels Of Unknown Composition And Dissimilar Steels

DESCRIPTION:

EutecTrode 670 has been specially formulated to meet the critical metallurgical demands when joining stainless and mild steels of unknown composition. Its composition also makes it an ideal candidate product when welding dissimilar steels and when such steels need scaling resistance up to 1800°F.

- Fully Austenitic structure helps retain mechanical properties
- Excellent in Salt-rich environments
- Corrosion Resistance: High resistance to corrosion and spalling
- Temperature Resistance: Effective in environments with high temperatures up to 1800°F

Product Details

- High alloy content electrode, used for welding steels of unknown composition and dissimilar steel

APPLICATIONS:

Use in marine applications such as salt-water discharge pumps, desalination equipment, furnace baskets that work in both carburizing and reducing environments, salt baths used in drawing and tempering operations.

PROCEDURE FOR USE

- Preparation: Clean weld area of scale and/or oxide. Angle prepping normally involves close- butts and infrequently bevel preparations. If needed, a 60° bevel is acceptable. Preheat and inter-pass temperatures will depend on the grade of steel, if known. Unknown grades should be nominally preheated within a -200 300°F range.
- Technique: A short, non-contact technique is recommended for both fillet and butt welding. Use a slightly longer arc length for bead- on-plate welding. Deposit stringer beads or 2x to 3x weave beads. Do not weave more than three times the electrode diameter otherwise slag interference will be encountered.
- Post-welding: Parts which have been preheated should be wrapped or covered with heat – retardant material to help with slow cooling.

TECHNICAL DATA:

- Tensile Strength: 655 N/mm² (95,000 psi)
- Yield Strength: 448 N/mm² (65,000 psi)
- Current & Polarity: AC/ DC (+)

DIAMETER	AMPERAGE
3.2mm	70-100
4.0mm	110-150

Note: for optimum results use the lowest amperage practical.