Xuper 680 CGS

High-Alloy Electrode For Welding Dissimilar, Unknown And Problem Steels

DESCRIPTION:

Xuper 680 CGS is a high-alloy electrode designed for critical maintenance and repair applications. It is suitable for a wide range of high alloy steel components, providing maximum repair reliability and extended part service life. The electrode is known for its superior crack resistance and high mechanical properties, ensuring an excellent in-service Maximum Safety Margin (MSM).

Product Details

- Repairs to most high alloy steel components
- Maximum repair reliability
- Extended part service life
- Reduced inventory carrying costs
- Improved silicon content for grain size control and weldability.
- High-Alloy Electrode for welding dissimilar, unknown, and problem steels

APPLICATIONS

- Repairs to most high alloy steel components
- Jigs, molds, dies, leaf springs
- High-strength repairs to earthmoving, mining, and constructional equipment chassis
- Under carriage repairs, composite die fabrications, manganese steel components

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 400-500°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 slow cool parts...critical for Tools & Dies.

TECHNICAL

- Tensile strength:830 N/mm2 (120,000 psi)
- Yield strength: 545 N/mm2 (79,000 psi)
- **Current polarity:** AC/DC (+)

DIAMETER	AMPERAGE
1.6mm	25-40
2.0mm	35-50
2.5mm	55-70
3.2mm	75-95
4.0mm	90-115
5.0mm	135-190

Note: For optimum result use the lowest amperage practical