EutecTrode EC 6821

Electrode For High Strength Joining Of Mn Steel, Low Alloy Steel & Medium Carbon Steel.

Description

High chrome manganese alloy electrode for TeroCote protective coatings and cushion layers on carbon steels, low or high alloy steels, and manganese steels.

- Maximal resistance to impact and pressures.
- Very work-hard enable deposit.
- Excellent AC/DC weldability.
- Machinable with cutting tools.
- Can be contact welded.
- Easy slag removal.
- Excellent crack resistance by absorption of internal stresses.
- Magnetic deposit

Product Details

- CrMn alloy electrode used for buffer layers and manganese steels

APPLICATIONS

- Buckets, book stick, C frame & undercarriage components of earthmoving equipment, Conveyor rollers ,Grading screens, Gyratory crusher cones
- Buffer layers for hard facing

PROCEDURE FOR USE

Preparation: Obtain a good surface by removing worn metal with ExoTrode or by mechanical means.

Preheating: Depends on the steel's Carbon Equivalent and the work piece size, thickness, and geometry.

CE < 0.2 : preheating not essential.

CE 0.2 - 0.4: preheating 100-200°C

CE 0.4 - 0.8 : preheating 200-350°C

Note: 12-14% Mn steels should never be preheated and the work piece temperature during welding should be kept below 250°C.

Welding: Keep a short arc, the electrode slightly sloping, possibility of contact welding. Follow welding procedures exactly.

TECHNICAL DATA

Tensile strength : 58kg /mm^2 (84,000 psi)

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	55-100
4.0mm	85-140
5.0mm	135-185

Note: For optimum result use the lowest amperage practical