



Superior Electrode for High Strength
Joining of Dissimilar Steels

EutecTrode® 3026N/4026N



- Tough two-phase micro-structure
- Smooth deposits
- Easy to de-slag
- Excellent compressive strength

3026N/4026N

EutecTrodes 3026N and 4026N combine ease of welding with optimized mechanical properties. Formulated with the welder in mind, they have easy strike and restrike properties, self-releasing slag and smooth, porous-free weld deposits.

TECHNICAL DATA

Typical Values

Tensile Strength:	120,000 psi (827 N/mm ²)
Yield Strength:	79,000 psi (545 N/mm ²)
Elongation:	(1=5d) min.: 25%
Hardness:	90 HRB as deposited
Max. Temperature:	800°F (427°C) steady-state
Current polarity:	DCEP (+) and AC

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	40-80	65-120	90-150

PROCEDURE FOR USE

PREPARATION: Clean weld area of scale and/or oxide. Angle prepping normally involves close-butts and/or bevel preparations. If a joint preparation is 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 help with slow cooling.

TYPICAL APPLICATIONS

Earthmoving Equipment, Welding Wear Strips, Bucket Teeth Inserts, Leaf and Coil Springs, Cracked Chassis, Scraper Blades, Intake Valves, Joining Manganese Steel, Removing Broken Casting Studs, Facing Worn Gear Teeth.



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