



Superior Chromium Carbide
Hardfacing Electrode

EutecTrode®

4004N



- Excellent weldability on all carbon and alloyed steels, manganese and cast irons
- Maximum wear resistance for abrasion and abrasion with impact
- High concentration of wear-resisting chromium carbides

4004N

Eutectrode 4004N weld deposits are ideal for combating general abrasion when impact is expected. Deposits polish in service to further reduce the rate of wear. A unique matrix further imparts high compressive strength to resist in-service spalling.

TECHNICAL DATA

Typical Values

Carbide % avg. count:	Medium-to-High
Carbide Hardness (VPN):	~1200 (Cr7C3)
Hardness as-deposited:	HRC 55-60
Current & Polarity:	DCEP (+) and AC

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
AMPERAGE	120-150	130-170	170-230

PROCEDURE FOR USE

PREPARATION: Clean weld area of scale and/or oxide. A nominal preheat of 150°F is advised if part is below 40°F or over 1" thick. For higher carbon steels higher preheats will be needed.

Note: Do not preheat Hadfield manganese steel castings above 400°F as this will cause temperature embrittlement

TECHNIQUE: Maintain a medium arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2 x the electrode diameter) is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit wear properties. Back whip craters to reduce crater cracking tendencies.

POST-WELDING: Allow parts to slow cool in still air. High carbon steels and air hardenable steels should be covered with a heat-retardant blanket.

TYPICAL APPLICATIONS

Augers, Crusher liners, Scrapers, Dredge Pumps
Dipperteeth/Lips, Muller Tires, Anvils, Dredger
Parts, Bucket Arms, Pug Mill Paddles, Impactor Bars
Tamper Tips, Pusher Shoes, Auger Bits and Ore Chutes.



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