



Specially Formulated Electrode for Parts
Subject to Impact at Elevated Temperatures

EutecTrode® 6899 XHD



- Excellent high temperature oxidation and abrasion resistance
- Work-hardens for additional toughness and extended service life
- For the cladding of most steel, nickel-based and heat-treatable tool & die alloys

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EutecTrode 6899 XHD is a nickel based alloy with excellent toughness and wear property retention up to 1100°F (595°C). The specially formulated coating allows deposition rates up to 97% faster than conventional wear-facing electrodes.

TECHNICAL DATA

Typical Values	
Hardness:	22 - 28 HRC As Deposited 36 - 42 HRC Work Hardened
Current & Polarity:	AC/DCEP (+)

SUGGESTED WELDING PARAMETERS:

Diameter	Amperage
3/32"	60 - 80
1/8"	85 - 140
5/32"	120 - 165
3/16"	170 - 220

Note: Values given above are recommended starting ranges. Heavier sections and larger build-ups may use larger amperages. Please contact Eutectic Technical Services at 800-558-8524 for further information.

PROCEDURE FOR USE

PREPARATION: Remove fatigued metal with Eutectic ChamferTrode or ExoTrode and clean area of any residual scale or oxides. Preheat to a nominal 150°F (65°C) is advised if the part is below 40°F (4°C) or over 1" thick and should be maintained for 1 hour per inch of thickness. Consult references for preheat temperature appropriate for highly hardenable or tool & die steels.

TECHNIQUE: Maintain a short arc to deposit stringer beads. A weave technique may be used, but larger than 2x the electrode diameter is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit properties. Back whip crater to avoid crater-cracking tendencies.

POST-WELDING: Allow parts to cool in still air. High hardenable steels and tool & die steels should be wrapped in insulative material to appropriately control the cooling rate.

TYPICAL APPLICATIONS

APPLICATIONS	INDUSTRY
• Augers	• Agriculture
• Forming Dies	• Automotive
• Hammermill Hammers	• Lumber
• Steam Valves and Seats	• Glass
• Hot Cutting Tools	• Forge Shops
• Hot Forming Rolls	• Natural Gas
• Impact Dies	
• Press Dies and Punches	

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before begin-ning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



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