



All-Position, Tubular Hardfacing
Electrode Combats Fine Partical Abrasion,
2-Body Abrasion and Light Impact

EutecTrode®

7030



- Designed for maximum efficiency and productivity
- Maintains high temperature hardness to 1000°F (538°C)
- Slag-free weld deposits
- Low operating current and low heat input

EutecTrode® 7030

EutecTrode 7030 is specifically formulated to resist fine particle erosion, 2-body abrasion and light impact while maintaining deposit hardness up to 1000°F (538°C). This all-position, tubular electrode has a high deposition rate for increased efficiency, productivity, coverage and usability. When used at low amperage, dilution is minimized and the key wear resistant properties are maintained. EutecTrode 7030 possesses built-in moisture resistance.

TECHNICAL DATA

Typical Values	
Hardness as-deposited:	HRC 55 - 60
Carbide Content:	Medium to High
Carbide Hardness:	1100 - 1200 VHN (M_7C_3) (M = Cr-W-Cb-Mo)
Typical Temperature Range:	1000°F (538°C)
Current polarity:	AC or DCEP/N (+/-)

DIAMETER	1/4" (6.4mm)	3/8" (9.5mm)	1/2" (12.7mm)
AMPERAGE	95-145	130-190	200-430

PROCEDURE FOR USE:

PREPARATION: Clean weld area of scale and/or oxide. A nominal preheat of 150°F (65.5°C) is advised if the part is below 40°F (4°C) or over 1" thick. For higher carbon steels higher preheats will be needed.

Note: Do not preheat Hadfield manganese steel castings above 400°F (204°C) as this will cause time-temperature embrittlement.

TECHNIQUE: Maintain a medium-to-short arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2x 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.

Do not deposit more than two layers.

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

APPLICATIONS

- Ripper Shanks
- Impeller Bars
- Stripper Bars
- Grizzly Bars
- Drag Chain Links
- Cement Chutes
- Clinker Belt Links
- Skip Car Lips
- Discharge Chutes
- Cone Crusher Rolls
- Fan Blades

INDUSTRY

- Quarrying
- Mining / Quarrying
- Quarrying
- Cement Works
- Mining
- Cement Works
- Cement Works
- Cement Works
- Deep Mining
- Cement / Quarrying
- Quarrying
- Various



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



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