



Superior Impact, Strength and
Crack Resistance on Carbon Steels

EutecTrode® N102 XHD



- Easy and complete slag removal
- No surface cross-checking
- Excellent for field repairs
- High deposition rate
- Welder-friendly

EutecTrode® N102 XHD

N102 XHD is a general purpose hardfacing alloy for parts subjected to abrasive wear and impact. This specially designed electrode allows for out-of-position welding with ease. Due to a low susceptibility to cracking, multi-pass welds are possible.

TECHNICAL DATA

Typical Values

Hardness as-deposited:	48-52 HRC
Current & polarity:	AC/DC (+)

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	125-135	175-190

NOTE: When welding vertical-up, set the amperage level between 100-110 amps...typically 100 amps would be optimum.

PROCEDURE FOR USE

PREPARATION: Clean the weld area and remove scale and oxide. For parts below 40°F or over 1" thick, preheat to 150°F. Higher carbon steels require higher preheat (300°F - 500°F). Do not preheat Hadfield manganese steel castings.

TECHNIQUE: Maintain a medium to short arc. The electrode should be inclined at a 30-45° angle in the direction of travel. Weld using stringer beads or 2x weaving. For vertical up welding, a weave technique is recommended. Be advised that weaving more than 2x the electrode diameter is not advised as it may overheat the base metal and degrade weld deposit wear properties. Prior to extinguishing the arc, back whip the craters to reduce crater cracking.

NOTE: When welding vertical-up set the amperage level between 100-110 amps...typically 100 amps would be optimum.

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

TYPICAL APPLICATIONS

Shredders
Feed Screws
Bucket Teeth
Roll Crushers

Recycling
Pulp and Paper
Mining
Iron and Steel Works



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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