

EUTECTIC 2B

A MACHINABLE, IMPACT-RESISTANT ELECTRODE WITH HIGH COMPRESSIVE STRENGTH...EXCELLENT CUSHIONING ALLOY

General Properties

Eutectic 2B is principally formulated to resist severe impact on plain carbon steels, low-alloy steels, and many construction steels. Deposits have high compressive strength which makes them ideal for re-builds involving a cushion layer followed by a harder final hardface.

Applications

For build-ups prior to hardfacing and for slideways, wheel crowns, guides & couplings, rope winches and brake drums, etc...

Technical Data

• Hardness as-deposited (Rc)	30	
• Current & Polarity	DCEP (+) and AC	
• Diameters	1/8-3.2mm	5/32-4.0mm
• Amperage Range	90-110	120-180

Welding Procedure

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. Check the Reference Section for information regarding specific preheating levels for specific steel grades.

Technique: Deposit stringer beads or 2x to 3x weave beads. Excessive weaving 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. When de-slagging make sure to thoroughly remove slag at the weld deposit toes.

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. When machining is needed use tool set-up & speeds typically used with fine-grained pearlitic steels.

