

Universal Cobalt Electrode

EutecDur[®] 9060N



WELDING

- High temperature hardness stability
- Excellent anti-galling
- Extremely high resistance to cavitation erosion
- Excellent resistance to oxidation and corrosion



DESCRIPTION:

EutecDur 9060N alloy is a uniquely formulated cobalt electrode with broad-based properties. Key application attributes to 9060N are high temperature hardness stability, excellent anti-galling features, and highly specific resistance to cavitation-erosion forces. Weld deposits have excellent resistance to oxidation and corrosion.

All cobalt-base alloys should be used with proper pre-heat levels, interpass temperature controls and prescribed cooling rates. Contact Eutectic Technical Services for more information on welding EutecDur 9060N and other cobalt-base products.

TECHNICAL DATA:

Polarity: DCEP (+) and AC

Typical Hardness (2 passes): 39-43 HRC

Typical Hot Hardness: 20 HRC average at 1200°F (649°C)

Diameter:	1/8" (3.2mm)	5/32" (4.0mm)
Amperage:	80-120	130-160

WELDING PARAMETERS:

Preparation: Remove all contaminants, particularly oil and grease. Lightly grind surface to remove superficial oxides. Preheat according to the base metal make-up and potential to air harden. For tool steel surfacing use the recommended preheat and interpass temperatures for the grade and type.

Technique: Always use the lowest practical amperage range to minimize dilution. Deposit width should be between 1/2" and 3/4". De-slag. Second, and subsequent passes should tie in to the weld deposit toe so as to avoid interpass "valleys". Alternate weld layer deposit sequence going from 9 o'clock to 3 o'clock then 12 o'clock to 6 o'clock.

Post-welding: For air-hardening steels slow cool using available insulating materials. For less sensitive base metals slow cool out of drafts.

TYPICAL ANTI-WEAR APPLICATIONS & INDUSTRIES:

APPLICATIONS

Valve Plugs and Seats
Hot Work Dies - Upset Dies
Furnace Retorts
Hot Forming/Forging Dies
Hot Punches - Trim Dies
Coke Pusher Shoes

INDUSTRY

Thermal Power
Stamping, Forging
Cement, Power
Forging Steel Works
Stamping
Steel Works, Foundry

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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