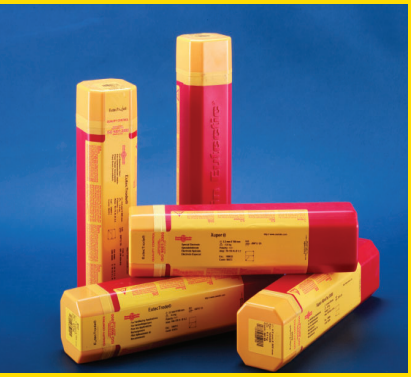
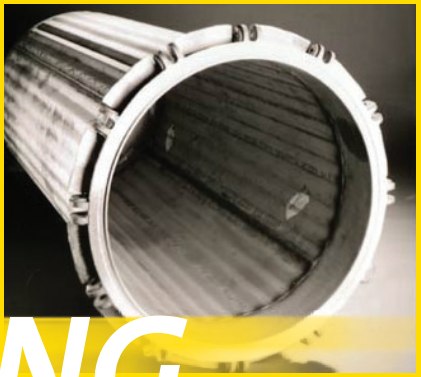
Premium Electrode with Optimized Properties Against Hot Impact, Erosion, Cavitation and Hot Abrasion

EutecDur® 9080N





WELDING

- Outstanding high temperature hot-hardness properties
- Excellent resistance to impact and thermal cycle cracking
- Temperature tolerant up to 1500°F

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

EutecDur 9080N is designed for exacting applications involving elevated temperature service. Excellent broad-based mechanical and thermal properties coupled with superior machinability position this alloy for critical surfacing and repair operations across a wide range of applications.

Weld deposits resist steam erosion and contact erosion from liquid metals. Ideal for withstanding hot metal erosion.

TYPICAL APPLICATIONS:

APPLICATIONS	INDUSTRY
Valve Plugs and Seats	Thermal Power Plants
Hot Work Dies - Upset Dies	Stamping, Forging
Furnace Retorts	Cement, Power
Hot Forming Dies - Forging Dies	Forging Steel Works
Hot Punches - Trim Dies	Stamping
Coke Pusher Shoes	Steel Works, Foundry

TECHNICAL DATA:

Typical Hardness (2-passes): HRC: 28 - 30
Typical Hot Hardness (2-passes): HRC: 18 avg. at 1200°F
Current & Polarity: AC or DCEP (+)

Availability and Recommended Amperages

Dia.	1/8“ 3.2mm	5/32“ 4.0mm	3/16“ 5.0mm
Amp.	70-110	90-135	130-175

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 its potential to air harden. For tool steel surfacing use the recommended preheat and inter-pass temperatures for the grade and type.

Technique: Always use the lowest practical amperage range to minimize dilution. Deposit width should be between ½“ and ¾“. De-slag. Second and subsequent passes should tie into the weld deposit toe so as to avoid inter-pass „valleys“. Alternate weld layer deposit sequence going from 9 o‘clock to 3 o‘clock then 12 o‘clock to 6 o‘clock. Utilize a run-off strip or back whip craters to reduce crater-cracking tendencies.

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

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS

Castolin Eutectic® Eutectic Castolin

EUTECTIC CORPORATION
N94 W14355 Garwin Mace Drive
Menomonee Falls, WI 53051 USA
Tel.: +1 (800) 558-8524
eutectic.com

EUTECTIC CANADA
428, rue Aimé-Vincent
Vaudreuil-Dorion, Québec
J7V 5V5 Canada
Tel.: +1 (800) 361-9439
eutectic.ca

Statement of Liability: Due to variations inherent in specific applications, the technical information contained herein, including any information as to suggested product applications or results, is presented without representation or warranty, expressed or implied. Without limitation, there are no warranties of merchantability or of fitness for a particular purpose. Each process and application must be fully evaluated by the user in all respects, including suitability, compliance with applicable law and non-infringement of the rights of others, and Eutectic Corporation and its affiliates shall have no liability in respect thereof.

9080 06/17 © 2008, Eutectic Corporation, ® Reg. T.M., Printed in the U.S.A.