

A Machinable, Impact-Resistant Electrode with High Compressive Strength

Eutec Trode® 2B



WELDING

- Excellent cushioning alloy
- Deposits exhibit high compressive strength
- Resists severe impact on plain carbon, low-alloy and construction steels



DESCRIPTION:

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

TYPICAL APPLICATIONS:

- Build-up prior to hardfacing
- Slideways
- Wheel Crowns
- Guides and Couplings
- Rope Winches
- Brake Drums

TECHNICAL DATA:

Typical Hardness as-deposited: 30 HRC

Current & Polarity: DCEP (+) and AC

Availability and Recommended Amperages

Dia.	1/8" - 3.2mm	5/32" - 4.0mm
Amp.	90-110	120-180

WELDING PARAMETERS:

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 pre-heating levels for specific steel grades.

Technique: Deposit stringer beads or 2 times to 3 times 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-slugging 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 and speeds typically used with fine-grained pearlitic steels.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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