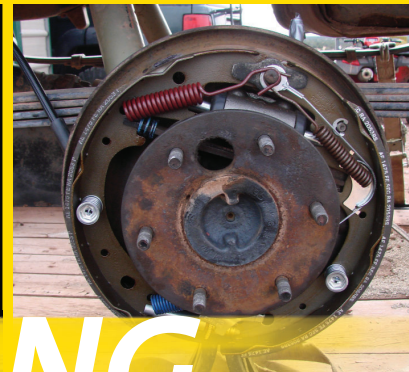


An All-Position Electrode for Build-Up and Cushioning of Steels

EutecTrode® 4002



WELDING

- High compressive strength
- Excellent resistance to severe impact with mild abrasion
- Fully machinable



DESCRIPTION:

EutecTrode 4002 has been 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 hardface.

TYPICAL APPLICATIONS:

- Slideways
- Wheel crowns
- Guides & couplings
- Rope winches
- Brake drums

TECHNICAL DATA:

Typical Hardness as-deposited (HRC) 28 – 30 average
Current & Polarity: DCEP (+) and AC

Availability and Recommended Amperages

Dia.	1/8" - 3.2mm	5/32" - 4.0mm	3/16" -(4.8mm)
Amp.	90-110	120-180	205-245

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 of the Eutectic Data Book or call Eutectic Technical Services 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 and speeds typically used with fine-grained pearlitic steels

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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