

Quality Low-Hydrogen Electrode with Welds of X-Ray Integrity

# EutecTrode® 66N



## WELDING

- Superior arc stability with virtually spatter-free metal transfer
- “N” formulation enables all diameters to be operated at lower amperage levels
- Deposits have moderately heavy slag, which is extremely easy to remove



## DESCRIPTION:

EutecTrode 66N is an all-position electrode with excellent bead control, crack resistance and mechanical properties.

66N is suitable for most carbon and low-alloy steels, including use as a scavenger of “tramp” elements in the welding of high sulfur or phosphorous bearing steels.

## TYPICAL APPLICATIONS:

- General boiler welding
- Ship hull construction
- Pressure vessels and connections
- Heavy-duty equipment
- Metal-production fabrication

## TECHNICAL DATA:

Recommended Polarity: DCEP (+) or AC (~)  
Typical Tensile Strength: 85,500 psi  
Typical Yield Strength: 73,200 psi  
Typical Elongation (1=5d) min.: 22%

## Availability and Recommended Amperages

A: Thick Sections, Heavy Build-Up (Multi-Pass)				
Diameter	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (5.0mm)
Amperage	75-100	120-160	170-200	230-275
B: Thin Sections, Out-Of-Position				
Diameter	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (5.0mm)
Amperage	55-70	100-120	140-175	NA

## WELDING PARAMETERS:

**Preparation:** Clean all weld surfaces, paying particular attention to removing grease, oil and rust. Prepare joints mechanically or use Xuper®ExoTrode® surface preparation electrodes to scarf open a nominal 60° “V”. Lightly grind or brush surfaces to remove slag, oxides and debris which might contaminate the weld.

**Preheat and Interpass Temperatures:** Temperature ranges are determined from both the carbon and alloy content of the base metal. For some low alloy, high-tensile steels, a preheat of 500° F (260° C) is recommended.

**Welding:** Maintain a short to medium arc length and avoid contact welding. Deposit stringer beads of no more than two times the electrode diameter. Back-whip all craters.

Use of Run-off tabs is highly recommended to avoid stop-start porosity and embrittlement, especially on hardenable steels.

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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