

Reverse Polarity Electrode for Build-Up , Overlaying and Joining Nickel and Steel Alloys

EutecTrode® 6800



WELDING

- Lower operating amperages prevents overheating
- Provides stability at higher temperatures (1700°F, and higher)
- Ultimate in resistance to deformation
- Deposits highly resistant to oxidization and corrosion
- Deposits are fully machineable, a good color match to nickel



DESCRIPTION:

EutecTrode 6800 is a high nickel alloy electrode for build-up, coating and joining nickel and steel alloys. It provides reduced overall sensitivity to electrode overheating. Deposits are hard and tough, for resistance to wear and heat-impact conditions. Special additives, such as Diamax®, lend exceptional heat resistance to weld-repaired parts.

EutecTrode 6800 deposits are extremely uniform in appearance, and fully machineable to a high finish. They're a good color match to nickel. Deposits are tough and hard, with hardness increasing in service. They resist impact, heat and corrosion. Deposit qualities are maintained to a high degree under elevated temperatures and rapid temperature changes.

TECHNICAL DATA:

Current: AC-DC Reverse Polarity
Typical Tensile Strength: 85,000 psi
Hardness: 210 BHN (work hardens in service)
Sizes Available: 3/32", 1/8", 5/32", 3/16". 14" Length

THICK SECTIONS, HEAVY BUILD UP (MULTI-PASS)

Electrode (Dia)	Amperage (A)
3/32"	75-90
1/8"	105-130
5/32"	145-180
3/16"	165-200

THIN SECTIONS, OUT OF POSITION

Electrode (Dia)	Amperage (A)
3/32"	50-65
1/8"	70-95
5/32"	100-135
3/16"	125-155

WELDING PARAMETERS:

When repairing worn dies or components, remove all worn metal. Xuper® ExoTrode® is recommended for this operation. Apply EutecTrode 6800 using AC or DC Reverse Polarity. Preheat is usually not necessary unless very heavy sections are involved.

When surfacing and cladding, both beading and weaving techniques may be used. When fabricating high alloys, stringer beads are preferred. Hold a close arc and back-whip craters. Remove slag before building up.

TYPICAL APPLICATIONS:

- Blocker Dies
- Die Rings
- Retorts
- Vats
- Plating Tanks
- Shear Blades
- Cutting Tools
- Rollers
- Rams
- Press Punches
- Ingot Tongs
- Pipe Lines

TYPICAL BASE METALS:

Carbon steels, low and medium alloy steels, nickel-based alloys, stainless steels, and gray and alloyed cast irons

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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