

Specially Formulated Electrode for Parts Subject to Impact at Elevated Temperatures

EutecTrode® 6899 XHD



WELDING

- Excellent high temperature oxidation and abrasion resistance
- Work-hardens for addition toughness and service life
- For the cladding of most steel, nickel-based and heat-treatable tool & die alloys



DESCRIPTION:

Eutectic XHD is a nickel based alloy with excellent toughness and wear property retention up to 1100°F (595°C). The specially formulated coating allows deposition rates up to 97% faster than conventional wear-facing electrodes.

TECHNICAL DATA:

Typical Hardness: 22-28 HRC As Deposited,
36-42 HRC Work Hardened
Current & Polarity: AC/DCEP (+)

PARAMETERS

Diameter	Amperage
3/32"	60-80
1/8"	85-140
5/32"	120-165
3/16"	170-220

Note: Values given above are recommended starting ranges. Heavier sections and larger build-ups may use larger amperages. Please contact Eutectic Technical Services at 800-558-8524 for further information

PROCEDURE FOR USE:

Preparation: Remove fatigued metal with Eutectic ChamferTrode or ExoTrode and clean area of any residual scale or oxides. Preheat to a nominal 150°F is advised if the part is below 40°F or over 1" thick and should be maintained for 1 hour per inch of thickness. Consult references for preheat temperature appropriate for highly hardenable or tool & die steels.

Technique: Maintain a short arc to deposit stringer beads. A weave technique may be used, but larger than 2x the electrode diameter is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit properties. Back whip crater to avoid crater-cracking tendencies.

Post-welding: Allow parts to slow cool in still air. High hardenable steels and tool & die steels should be wrapped in insulative material to appropriately control the cooling rate.

TYPICAL APPLICATIONS:

- Augers
- Forming Dies
- Hammermill Hammers
- Steam Valves and Seats
- Hot Cutting Tools
- Hot Forming Rolls
- Impact Dies
- Press Dies and Punches

TYPICAL INDUSTRIES:

- Agriculture
- Automotive
- Lumber
- Glass
- Forge Shops
- Natural Gas

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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