

All-Position, Tubular Hardfacing Electrode Combats Severe Abrasion  
and Medium Impact

# EutecTrode® 7020



## WELDING

- Designed for maximum efficiency and productivity
- Maintains high temperature hardness to 1000°F
- Moisture-resistant coating



## DESCRIPTION:

EutecTrode 7020 is a highly alloyed composition suitable for severe abrasion with medium impact and maintains deposit hardness up to 1000°F. This all-position, tubular electrode has a high deposition rate for increased efficiency, productivity, coverage and usability. When used at low amperage, dilution is minimized and the key wear resistant properties are maintained. EutecTrode 7020 possesses built-in moisture resistance.

## TYPICAL APPLICATIONS:

### Applications

- Pug mill augers
- Muller tires
- End-bits Dozers
- Sheepsfoot tampers
- Cage crushers
- Asphalt mixer paddles

### Industry

Raw material Processing  
Iron and Steel Works  
Various  
Construction  
Fertilizer Industry  
Civil Eng. / Construction

## TECHNICAL DATA:

Hardness As-Deposited:	HRC: 55 - 60
Typical Temperature Range:	1000°F
Carbide Content:	Medium
Carbide Hardness:	1100 - 1200 VPN ( $M_7C_3$ ) (M = Cr-W-Cb-Mo)
Current & Polarity:	AC or DCEP/N (+/-)

## Availability and Recommended Amperages

Dia.	1/4" 6.4mm	3/8" 9.0mm	1/2" 12.7mm
Amp.	85-135	130-190	200-430

## WELDING PARAMETERS:

**Preparation:** Clean weld area of scale and/or oxide. A nominal preheat of 150°F is advised if the part is below 40°F or over 1" thick. For higher carbon steels higher preheats will be needed.

**Note:** Do not preheat Hadfield manganese steel castings above 400°F as this will cause time-temperature embrittlement.

**Technique:** Maintain a medium-to-short arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2x the electrode diameter) 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.

**Do not deposit more than two layers.**

**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.

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