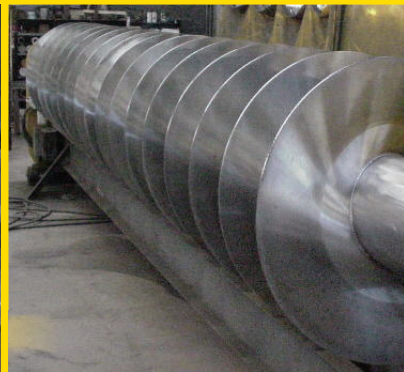


All-Position, Tubular Hardfacing Electrode Combats Severe Abrasion and High Temperature Erosion

# EutecTrode® 7040



## WELDING

- Designed for maximum efficiency and productivity
- Maintains high temperature hardness to 1500°F
- Moisture-resistant coating



## DESCRIPTION:

EutecTrode 7040 is formulated to resist severe abrasion and high temperature erosion up to 1500°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 7040 possesses built-in moisture resistance.

## TYPICAL APPLICATIONS:

Applications	Industry
• Ash Conveyor Links	Various Industries
• Feeder Screws	Various Industries
• Rotor & Impeller Bars	Various Industries
• Dust Collector Fans	Cement Works
• Ash Conveyor Elbows	Various Industries
• Sintering Plant Augers	Iron and Steel Works
• Kiln Flights	Cement Works

## TECHNICAL DATA:

Hardness As-Deposited:	HRC: 62 - 64
Typical Temperature Range:	1500°F
Carbide Content:	High
Carbide Hardness:	1250 - 1400 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	180-390

## 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.

## YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS



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