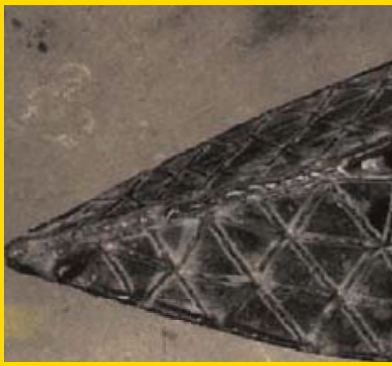
A High Efficiency Complex Carbide Hardfacing Electrode

EutecTrode® N 6060



WELDING

- Exceptional abrasion resistance
- Excellent weldability
- High efficiency metal recovery
- Contains ultra-hard complex carbides
- Minimal slag residues
- Out-of-position cap

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

EutecTrode N 6060 is a high efficiency complex carbide alloy electrode containing controlled percentages of hard constituents producing, extremely hard deposits up to 842°F (450°C).

This alloy produces a deposit of fine metallurgical structure, which gives excellent resistance to abrasion by both fine and coarse mineral particles, particularly the former. Excellent metal recovery rates are obtained. The arc characteristics are of the "spray type" producing smooth, ripple-free deposits.

TYPICAL APPLICATIONS:

For protecting components against abrasion and erosion, especially where both fine and coarse grain mineral particles are present. Suitable for a wide range of steels including medium carbon steel, low alloy steels and austenitic manganese steels.

- Excavation tools, pocket-bins, bucket edges
- Extrusion screws
- Mineral, sand and gravel processing
- Mixing blades and scrapers

TECHNICAL DATA:

Hardness as-deposited: approx. 62 - 64 HRC
Welding Parameters
Current & Polarity: AC or DCEP
Positions: Flat, Horizontal and Vertical Up

Heavy Sections and High Deposition

Diameter	1/8" (3.2mm)	5/32" (4.0mm)
Amperage	155-165	205-215

Small Sections Minimum Dilution and Low Heat Input

Diameter	1/8" (3.2mm)	5/32" (4.0mm)
Amperage	100-140	120-180

TYPICAL WELDING PROCEDURE

PREPARATION: Completely remove all previous weld deposits or cracked metal with ChamferTrode.

PREHEATING: Preheating will depend upon type, size and carbon equivalent of the base material. For a general guide:

For steels with a carbon equivalent of up to 0,25% carbon pre-heating is not essential. However, heating up to 212°F (100°C) may be applied.

For steels between 0,25% and 0,45% carbon equivalent pre-heating between 212°F - 482°F (100°C - 250°C) is recommended. Steels above 0,45% carbon equivalent, preheating between 482°F - 662°F (250°C - 350°C) is recommended.

Do not preheat austenitic manganese steels. Maintain compo-nents as cool as possible, and employ a balanced welding technique, in order to avoid local overheating.

TECHNIQUE: Select lowest possible amperage setting from the recommended range when depositing directly to the base material. EutecTrode 680 may be used as initial or intermediate layers especially on large or heavy build-up applications. For applications where impact and pressure is present deposit into pre-prepared grooves at a pitch not less than the width of the groove (two layers should be deposited into the grooves.

Maintain an arc length equal to the electrode diameter and a near vertical electrode angle. Limit each deposit length between 2" - 4" (50-100 mm).

POST-WELDING: Safely stack and store electrodes in a dry location to avoid humidity pick up or flux coating damage. If electrodes have absorbed moisture, the following re-drying conditions before use are recommended: 350°F (150°C) / 1-2 hr.

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS

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