

Superior Impact, Strength and Crack Resistance on Carbon Steels

EutecTrode[®] N102 XHD



WELDING

- Easy and complete slag removal
- No surface cross-checking
- Excellent for field repairs
- High deposition rate
- Welder-friendly



DESCRIPTION:

N102 XHD is a general purpose hardfacing alloy for parts subjected to abrasive wear and impact. This specially designed electrode allows for out-of-position welding with ease. Due to a low susceptibility to cracking, multi-pass welds are possible.

TECHNICAL DATA:

Typical Hardness (single pass): 48-52 HRC
Polarity: AC/DC (+)

Recommended Amperages

Diameter:	1/8" (3.2mm)	5/32" (4.0mm)
Amperage:	125-135	175-190

NOTE: When welding vertical-up, set the amperage level between 100-110 amps...typically 100 amps would be optimum.

TYPICAL APPLICATIONS:

APPLICATIONS	INDUSTRIES
Shredders	Recycling
Feed Screws	Pulp and Paper
Bucket Teeth	Mining
Roll Crushers	Iron and Steel Works

WELDING PARAMETERS:

Preparation: Clean the weld area and remove scale and oxide. For parts below 40°F or over 1" thick, preheat to 150°F. Higher carbon steels require higher preheat (300°F - 500°F). Do not preheat Hadfield manganese steel castings above 200°F.

Technique: Maintain a medium to short arc. The electrode should be inclined at a 30-45° angle in the direction of travel. Weld using stringer beads or 2x weaving. For vertical up welding, a weave technique is recommended. Be advised that weaving more than 2x the electrode diameter is not advised as it may overheat the base metal and degrade weld deposit wear properties. Prior to extinguishing the arc, back whip the craters to reduce crater cracking.

NOTE: When welding vertical-up set the amperage level between 100-110 amps...typically 100 amps would be optimum.

Post-welding: Slow cool parts 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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