



Multi-Carbide Hardfacing Electrode

# **AbraTec® 6715 XHD**



- Exceptional wear resistance against high temperature abrasion
- Achieves final hardness in a single pass
- Extended part service life
- Deposit hardness attained with a refined mix of primary and secondary carbides
- Welds with a deposition rate double that of conventional electrodes

# AbraTec® 6715 XHD

AbraTec 6715 XHD is a multi-carbide electrode that deposits smooth weld beads and is easily handled, especially in the flat position. The mix of primary and secondary carbides renders deposits that are resistant to high temperature abrasion up to 1200°F. 6715 XHD provides a single pass hardness of HRC 65. It can be used on carbon steels, low alloys steels, manganese steel castings and AR plate.

## TECHNICAL DATA

### Typical Values

Maximum Service Temp.:	1200°F
Hardness as-deposited:	HRC 64-66
Carbide Hardness:	VPN 1250 - 1400 ( $M_7C_3$ )*
Current & Polarity:	AC or DCEN/P (-/+)**

\*Note: The "M" stands for Cr-W-Cb-Mo

\*\*DCEP increases dilution and ductility. Recommended for impact applications. HRC 63-65. DCEN results in less dilution Recommended for sliding abrasion applications. HRC 65-68.

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
AMPERAGE	160-240	180-270	230-375

## PROCEDURE FOR USE

**PREPARATION:** Clean the weld area and remove scale and oxide. For parts below 40F of over 1" thick, preheat to 150°F. Higher carbon steels require higher preheats (300°F - 500°F) Do not heat Hadfield Manganese Steel castings above 400°F.

**TECHNIQUE:** Maintain a medium to short arc. The electrode should be inclined at a 45 angle in the direction of travel. Weld using stringers or weaving. be advised that weaving more than 2X the electrode diameter is not advised as it may overheat the base metal and degrade the weld deposit wear properties. Prior to extinguishing the arc, back whip the craters to reduce crater cracking.

**POST WELDING:** Slow cool parts in still air. High carbon steels and air hardenable steels should be covered with a heat retardant blanket.

## TYPICAL APPLICATIONS

### APPLICATIONS

Coal Burner Nozzles  
Coke Pusher Shoes  
Clinker Grinders  
Sinter Equipment  
Conveyor Screw  
Pug Mill Knives

### INDUSTRY

Thermal Power Plants  
Iron & Steel / Concrete  
Cement Works  
Iron & Steel Works  
Brick & Clay  
Material Processing



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