



Unique Chromium-Carbide  
Hardfacing Electrode

# ChromCarb® N6006



- Formulated for hardfacing of most carbon, low alloy and manganese steels
- Resistant to coarse particle abrasion with moderate gouging impact
- Provides dense, smooth, easy to clean weld deposits

# N6006

ChromCarb N6006 is an electrode for the overlay and protection of carbon, alloy and manganese steels. A high chromium carbide content makes it especially favorable against coarse particle abrasion, moderate gouging impact and mild corrosion in any number of service conditions.

## TECHNICAL DATA

### Typical Values

Carbide Hardness:	1200 (Cr <sub>7</sub> C <sub>3</sub> ) VPN
Hardness as-deposited:	57-60 HRC
Current & Polarity:	DCEP (+) or AC

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
AMPERAGE	90-130	120-160	150-210

## PROCEDURE FOR USE

**PREPARATION:** Clean weld area of scale and/or oxide. A nominal preheat of 150°F is advised if part is below 40°F or over 1" thick. For higher carbon steels, higher preheats will be needed. Check the Reference Section for information regarding specific preheating levels for specific steel grades.

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

**TECHNIQUE:** For base metals with high hardenability a buffer layer is highly recommended prior to application of ChromCarb N6006. For Manganese steels, use EutecTrode 40; for air-hardenable steels, use EutecTrode 680 and for cast irons, use Xuper 2233N. Only one pass of ChromCarb N6006 should be used on cast irons.

Maintain a medium arc, and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2 times 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.

**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.

## TYPICAL APPLICATIONS

- Muller Tires
- Anvils
- Dredger Parts
- Bucket Arms
- Pug Mill Paddles



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