



Universal Cobalt Electrode

EutecDur® 9060N



- High temperature hardness stability and anti-galling
- Extremely high resistance to cavitation erosion
- Excellent resistance to oxidation and corrosion

9060N

EutecDur 9060N alloy is a uniquely formulated cobalt electrode with broad-based properties. Key application attributes to 9060N are high temperature hardness stability, excellent anti-galling features, and highly specific resistance to cavitation-erosion forces. Weld deposits have excellent resistance to oxidation and corrosion.

All cobalt-base alloys should be used with proper pre-heat levels, interpass temperature controls and prescribed cooling rates.

Contact Eutectic Technical Services for more information on welding using EutecDur 9060N and other cobalt-base products.

TECHNICAL DATA

Typical Values

Hardness as-deposited:	(2 passes): 39-43 HRC
Hot Hardness:	20 HRC average at 1200°F (649°C)
Current & Polarity:	DCEP (+) and AC

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	80 - 120	130-160

PROCEDURE FOR USE

PREPARATION: Remove all contaminants, particularly oil and grease. Lightly grind surface to remove superficial oxides. Preheat according to the base metal make-up and potential to air harden. For tool steel surfacing use the recommended preheat and interpass temperatures for the grade and type.

TECHNIQUE: Always use the lowest practical amperage range to minimize dilution. Deposit width should be between 1/2" and 3/4". De-slag. Second, and subsequent passes should tie in to the weld deposit toe so as to avoid interpass "valleys". Alternate weld layer deposit sequence going from 9 o'clock to 3 o'clock then 12 o'clock to 6 o'clock.

POST-WELDING: For air-hardening steels slow cool using available insulating materials. For less sensitive base metals slow cool out of drafts.

TYPICAL APPLICATIONS

- Valve Plugs and Seats
- Hot Work Dies - Upset Dies
- Furnace Retorts
- Hot Forming/Forging Dies
- Hot Punches
- Trim Dies
- Coke Pusher Shoes



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