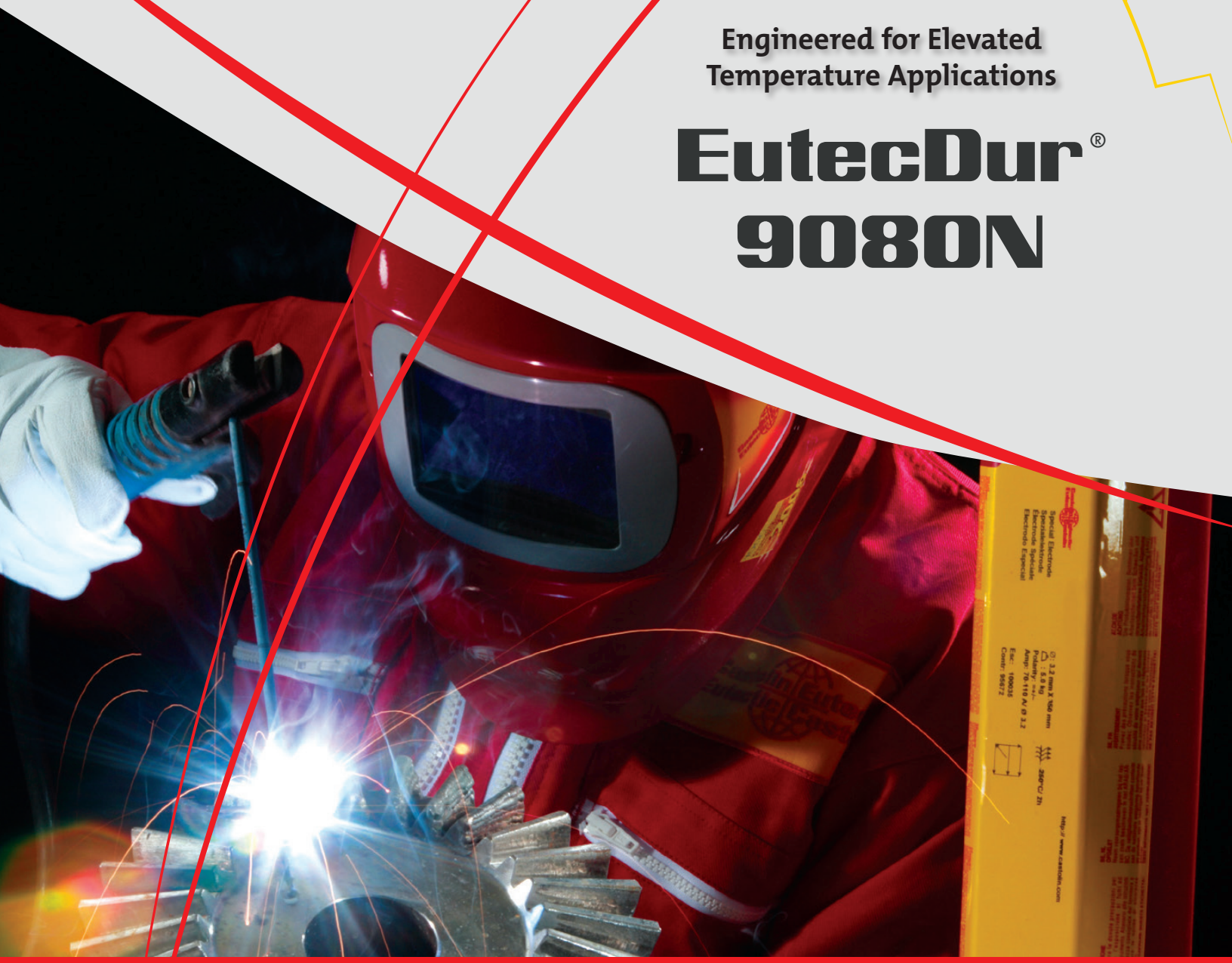
Castolin Eutectic®
Eutectic Castolin

Engineered for Elevated Temperature Applications

EutecDur® 9080N



- Outstanding high temperature hot-hardness properties
- Excellent resistance to impact and thermal cycle cracking
- Temperature tolerant up to 1500°F

9080N

EutecDur 9080N is designed for exacting applications involving elevated temperature service. Excellent broad-based mechanical and thermal properties coupled with superior machinability, position this alloy for critical surfacing and repair operations across a wide range of applications.

Weld deposits resist steam erosion and contact erosion from liquid metals. Ideal for withstanding hot metal erosion.

TECHNICAL DATA

Typical Values	
Hardness as-deposited:	(2-passes): HRC: 28 - 30
Hot Hardness:	(2-passes): HRC: 18 avg. at 1200°F
Current & Polarity:	AC or DCEP (+)

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	70 - 110	90 - 135

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 its potential to air harden. For tool steel surfacing use the recommended preheat and inter-pass temperatures for the grade and type.

TECHNIQUE: Always use the lowest practical amperage range to minimize dilution. Deposit width should be between ½" and ¾". De-slag. Second and subsequent passes should tie into the weld deposit toe so as to avoid inter-pass „valleys". Alternate weld layer deposit sequence going from 9 o'clock to 3 o'clock then 12 o'clock to 6 o'clock. Utilize a run-off strip or back whip craters to reduce crater-cracking tendencies.

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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Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca

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