



A Machinable, Impact-Resistant Electrode
with High Compressive Strength

EutecTrode® 2B



- Excellent cushioning alloy
- Deposits exhibit high compressive strength
- Resists severe impact on plain carbon, low-alloy and construction steels

EutecTrode® 2B

EutecTrode 2B is principally formulated to resist severe impact on plain carbon steels, low-alloy steels, and many construction steels. Deposits have high compressive strength that makes them ideal for re-builds involving a cushion layer followed by a harder final layer.

TECHNICAL DATA

Typical Values	
Typical Hardness as deposited:	30 HRC
Polarity:	DCEP (+) and AC

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
Amp	90-110	120-180	205-245

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.

WELDING TECHNIQUE

Deposit stringer beads or 2 times to 3 times weave beads. Excessive weaving 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. When de-slagging make sure to thoroughly remove slag at the weld deposit toes.

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. When machining is needed use tool set-up and speeds typically used with fine-grained pearlitic steels.

TYPICAL APPLICATIONS

- Build-up prior to hardfacing
- Slideways
- Wheel Crowns
- Guides and Couplings
- Rope Winches
- Brake Drums

