



Superior Electrode for Abrasion
with Moderate Impact

EutecTrode® 5003



- Welder friendly hardfacing electrode
- Excellent weldability on carbon, alloyed Steels, Manganese and cast irons.
- Supported by a high concentration of Chromium carbides
- Maximum wear resistance for abrasion combined with moderate impact

5003

EutecTrode 5003 is a conventional hardfacing product with improved weldability. Ideal for combatting abrasion when accompanied by moderate impact. Deposits polish while in service to further reduce the rate of wear.

TECHNICAL DATA

Typical Values

Hardness:	55-58 HRC as welded
Carbide Hardness (VPN):	1200 (Cr ₇ C ₃)
Carbide % Avg. count:	Medium
Current & Polarity:	DCEP (+) and AC

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	120-150	130-170

Note: Always keep electrodes in their container during storage. Damp electrodes can cause cracking and porosity. For re-drying procedures check with Eutectic Technical Services.

PROCEDURE FOR USE

PREPARATION: Clean weld area of scale and/or oxide. A nominal pre-heat of 150°F is advised if the part is below 40°F or over 1" thick. Note: Do not preheat Hadfield manganese steel castings above 400°F as this will cause time-temperature embrittlement.

TECHNIQUE: 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. The optimum bead width is a stringer bead. 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 to control the cool-down rate.

TYPICAL APPLICATIONS

Augers, Crusher Liners, Scrapers, Dredge Pumps
Dipper Teeth & Lips

