



Reverse Polarity Electrode for Build-Up,
Overlaying and Joining Nickel and Steel Alloys

EutecTrode® 6800



- Lower operating amperages prevent overheating
- Provides stability at higher temperatures - 1700°F (926°C), and higher
- Ultimate in resistance to deformation
- Deposits highly resistant to oxidization and corrosion
- Deposits are fully machineable, a good color match to nickel

EutecTrode® 6800

EutecTrode 6800 is a high nickel alloy electrode for buildup, coating and joining nickel and steel alloys. It provides reduced overall sensitivity to electrode overheating. Deposits are hard and tough, for resistance to wear and heat-impact conditions. Special additives lend exceptional heat resistance to weld-repaired parts.

EutecTrode 6800 deposits are extremely uniform in appearance, and fully machineable to a high finish. They're a good color match to nickel. Deposits are tough and hard, with hardness increasing in service. They resist impact, heat and corrosion. Deposit qualities are maintained to a high degree under elevated temperatures and rapid temperature changes.

TECHNICAL DATA

Typical Values	
Current & Polarity:	AC-DC Reverse Polarity
Tensile Strength:	85,000 psi
Hardness:	210 BHN (work hardens in service)

SUGGESTED WELDING PARAMETERS:

Thick sections, heavy build up (multi-pass)

Diameter	Amperage
3/32"	75 - 90
1/8"	105 - 130
5/32"	145 - 180
3/16"	165 - 200

Thin sections or out of position

Diameter	Amperage
3/32"	50 - 65
1/8"	70 - 95
5/32"	100 - 135
3/16"	125 - 155

PROCEDURE FOR USE

WELDING PARAMETERS:

When repairing worn dies or components, remove all worn metal. Xuper® ExoTrode® is recommended for this operation. Apply EutecTrode 6800 using AC or DC Reverse Polarity. Preheat is usually not necessary unless very heavy sections are involved.

When surfacing and cladding, both beading and weaving techniques may be used. When fabricating high alloys, stringer beads are preferred. Hold a close arc and back-whip craters. Remove slag before building up.

TYPICAL BASE METALS:

Carbon steels, low and medium alloy steels, nickel-based alloys, stainless steels, and gray and alloyed cast irons.

TYPICAL APPLICATIONS

- Blocker Dies
- Die Rings
- Retorts
- Vats
- Plating Tanks
- Shear Blades
- Cutting Tools
- Rollers
- Rams
- Press Punches
- Ingot Tongs
- Pipe Lines

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



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