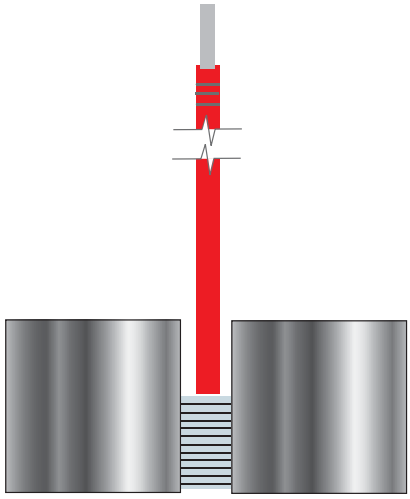
Castolin Eutectic®
Eutectic Castolin

Quick Reference Tool

Stud Removal with EutecTrode 9598 CEC



1)

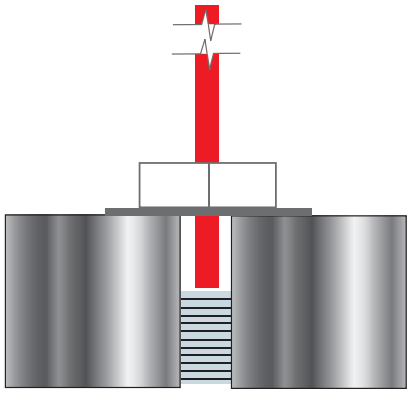
Choose the right size EutecTrode 9598 CEC. Make sure that the electrode can be centralized in the cavity without touching the edges.

Hold the electrode vertically in the center of the hole.

Strike the arc in the center of the broken stud and build-up in a sequence of short duration welds, allowing the weld to cool between passes. Ensure that the arc does not wander and weld the build-up to the cavity edges.

If you remain at the center, the unique flux will prevent the stud from fusing to the cavity walls.

Chip the slag at the center, to expose weld metal before next step.



3)

Place the nut on the washer centered over the hole.

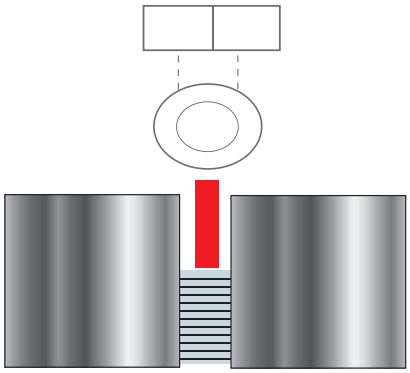
Weld through the nut and the washer and begin to allow the molten weld pool to fuse to the nut. Continue until the cavity of the nut is filled.

The weld deposit, along with the nut and washer, will act as an extension of the original fastener.

TECHNICAL DATA - SELECTION CHART:

Typical Tensile Strength: 120,000 psi
Typical Yield Strength: 94,000 psi
Typical Elongation: 27%

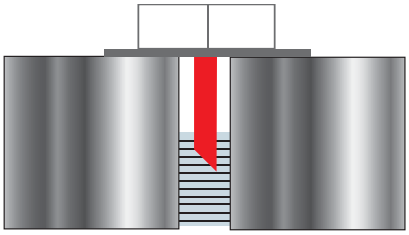
Stud Diameter	EutecTrode Diameter
up to 3/8”	3/32”
3/8” - 1/2”	1/8”
over 1/2”	5/32”



2)

Place a washer with an inner diameter less than the inner diameter of the cavity, over the cavity hole. This will act as a spacer.

Select a nut of equal or greater size then the head of the broken stud.



4)

Allow the area to cool to ambient temperature before proceeding.

<u>To remove the fastener, use hand tools only, do not use an impact wrench of any kind.</u>

Back out fastener with hand tools. After removal, chase the threads with a tap to remove slag residue.

Technical Services - 800-361-9439

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