



General Maintenance Alloy for the  
Maintenance and Repair of Low and  
High Alloy Steel Equipment and Parts

# **EutecTrode<sup>®</sup>**

## **9598 CEC**



- Economic solution to the general maintenance & repair of critical parts
- Very high tensile strength (120,000 psi)
- Exceptional weldability and mechanical properties
- Recommended for underlay prior to hardfacing
- Superior crack resistance
- Dense deposits, minimal dilution, easy strike and restrike

# EutecTrode® 9598 CEC

EutecTrode 9598 CEC is an all position electrode suitable for welding all steels and dissimilar steel combinations.

EutecTrode 9598 CEC features exceptional weldability at low amperage, an easy strike and restrike, and excellent mechanical properties. It has an extremely tough deposit that is easily machinable.

EutecTrode 9598 CEC, with its superior weldability and mechanical properties, is particularly suited for use as a buildup and cushion layer on tool steels.

## TECHNICAL DATA

Typical Values	
Tensile Strength:	120,000 psi
Elongation:	30%
Polarity:	AC or DC(+)

DIAMETER	Amperage Heavy Section	Amperage Thin Sections
1.6 mm (1/16")	N/A	25-45
2.4 mm (3/32")	70-85	45-60
3.2 mm (1/8")	100-120	70-90
4.0 mm (5/32")	120-145	85-110
4.8 mm (3/16")	195-235	145-185

## PROCEDURE FOR USE:

**PREPARATION:** Clean weld area of scale and/or oxide. A nominal preheat of 65°C (150°F) is advised if part is below 5°C (40°F) or over 25 mm (1") thick. For higher carbon steels, higher preheats will be needed. Do not preheat manganese steel castings above 205°C (400°F) as this will cause time-temperature embrittlement.

**TECHNIQUE:** Maintain the optimum electrode stickout and hold a 75° angle from the vertical in the direction of travel. Do not weave excessively. Wide beads can cause porosity, excessive base metal overheating, and degrade the weld deposit wear properties. Back whip craters to reduce cracking tendencies and potential out-gassing.

**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 or by other means. If steel composition is unknown, slow cool at a rate of 38°C (100°F) per hour.

## TYPICAL APPLICATIONS

The ferritic/austenitic balanced structure of EutecTrode 9598 CEC makes it ideally suited for use on dies as well as all other steel components.

Tools and dies, assembly of steels of varying thicknesses, cushion layer of TeroCote.



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