



NanoAlloy® Electrode for Manual
Wearfacing Applications

EutecTrode® XHD 6395N



- Unique NanoAlloy structure for unmatched abrasion and erosion resistance
- Produces tough uniform 67 HRC single and double pass weld deposits
- Wears like tungsten carbide at a fraction of the cost
- Outlasts chrome carbide and complex carbide alloys
- Ensures enhanced productivity and cost savings

XHD 6395N

Eutectrode XHD 6395N is based on the science and engineering of Nanotechnology. Weld deposits have a high volume fraction of ultra-hard, complex borocarbides distributed evenly in a unique, semi-amorphous iron alloy matrix. Easy to use and welder-friendly, 6395N offers a higher caliber of abrasion resistance reinforced by a tough, ductile matrix for added impact resistance. 6395N outperforms chromium and complex carbides by up to 40%! 6395N's wear resistance is equal to that of a 35% tungsten carbide alloy at a lower cost.

TECHNICAL DATA

Typical Values

Hardness:	67-70 HRC
Wear Resistance	(ASTM G65 Tests): 12mm3
Position	Flat
Current & Polarity	DC (+) or AC

Diameter	1/8" (3.2mm)	5/32" (4.0mm)
Amperage	120-150	150-175

TECHNICAL ADVANTAGES: The unique NanoAlloy type microstructure ensures performance above and beyond many carbide bearing products. 6395N protects against wear by severe abrasion, erosion combined with moderate impact from ambient to elevated service temperatures.

- Smooth ripple-free weld surface
- High efficiency metal recovery
- Precision grindable deposits
- Stress relieving cracks
- Easy striking and restriking for anti-wear patterns
- Retains high hardness properties at elevated temperatures
- Single pass attains close to maximum hardness
- First layer hardness 67 HRC, second layer 70 HRC
- Withstands thermal cycling up to 1200°F (650°C)

PROCEDURE FOR USE

PREPARATION: Remove all "old" cracked or spalled material down to a sound base. Clean any residual oxides, coatings, spatter or residue. For steels with higher alloy content or which require build-up greater than ¼" a 2-pass buffer layer of Eutectrode 680 is strongly recommended. Eutectrode 6395N is not recommended for applications beyond a 2 pass maximum. For best results apply Eutectrode XHD 6395N with as little heat as possible, allowing parts to cool between layers.

EUTECTRODE XHD 6395N SHOULD NOT BE USED ON MANGANESE/HADFIELD STEELS AS IT WILL NOT BOND!

TECHNIQUE: Position electrode at a 70-80° angle from the workpiece and use a "pull" technique. Maintain and moderate arc length. A slight weave to assist wetting characteristics is acceptable but should not exceed 2-3x the electrode diameter.

POST-WELDING: For most applications, other than a superficial grind, finishing is not required. If some level of profiling is needed, grinding is recommended.

STORAGE AND HANDLING:

- Store in a dry location to avoid possible moisture.
- Rebake Temperature: 300°F (149°C) for 1-hour.
- Care of Product: Coating is sensitive to moisture pick-up. Return unused product by inserting in a plastic bag before repacking.

TYPICAL APPLICATIONS

Designed for protective coatings with extreme resistance to abrasion, erosion combined with moderate shock on carbon, alloy, stainless and cast steels.

APPLICATIONS	INDUSTRIES
Bucket Teeth/Lips	Mining
Crusher Bars	Earth Moving
Shredders	Waste/Recycling
Feed Screws	Pulp and Paper
Roll Crushers	Iron and Steel Works
Dredging Teeth	Construction
Recycling Knives	Waste/Recycling



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