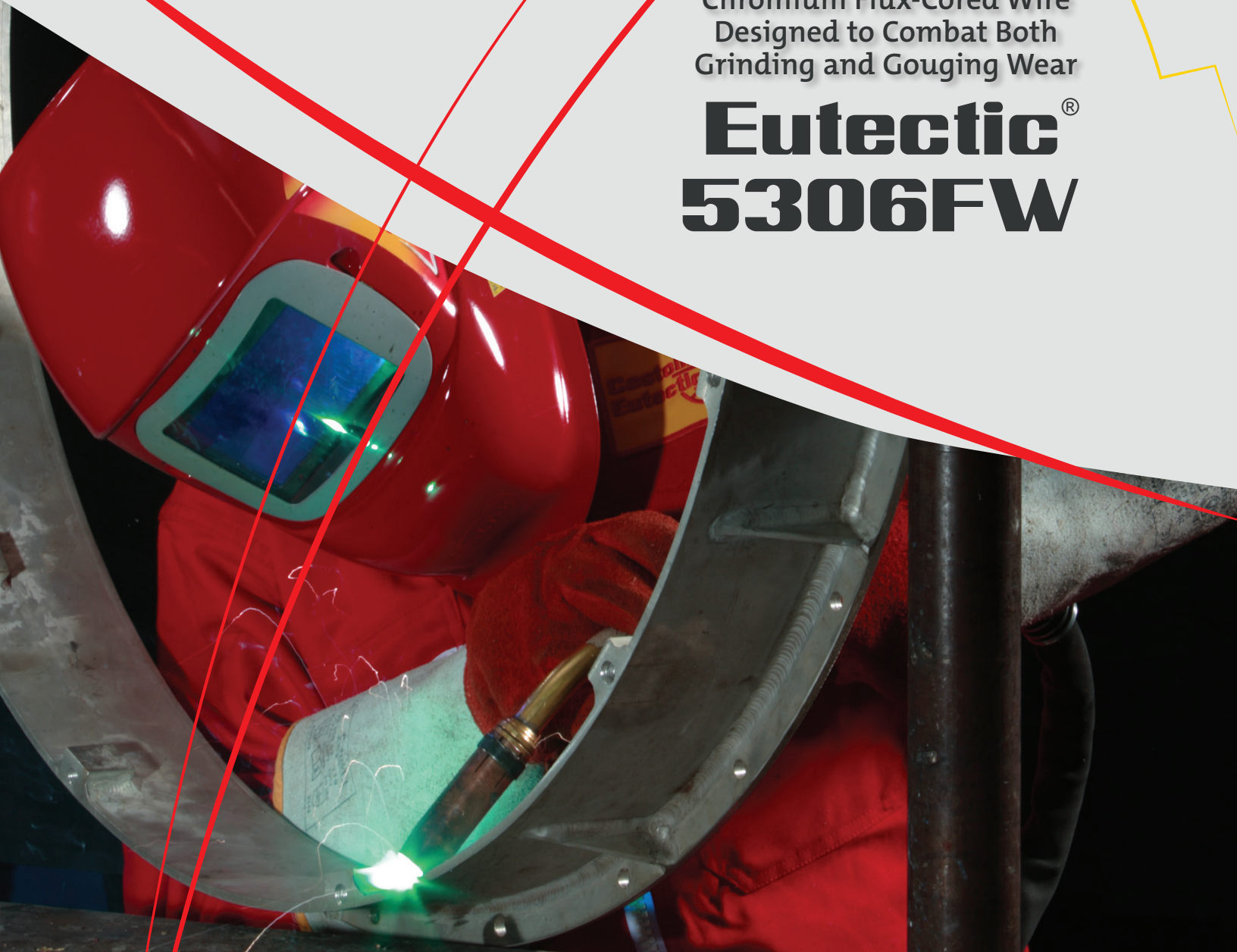




Chromium Flux-Cored Wire
Designed to Combat Both
Grinding and Gouging Wear

Eutectic[®] 5306FW



- Superior resistance to grinding and gouging abrasion with light impact at elevated temperatures
- Open arc wire for convenient, gas-free use in the field or shop
- High chromium Open arc wire for defect-free weldability in adverse conditions
- High chromium content imparts excellent oxidation resistance
- Small diameter wires are excellent for use with 110v welding machine

Eutectic® 5306 FW

5306FW is formulated to combat grinding and gouging from two- and three-body abrasion. High-Chromium precise, smooth deposits are easily achieved with conventional low-voltage welding machines. The chromium content takes a dual role in forming carbides to combat wear while protecting the weld metal from high temperature oxidation. The ability to be applied with or without shielding gas makes 5306 FW versatile as well as an outstanding performer in any number of field and shop applications.

TECHNICAL DATA

Typical Values	
Hardness:	56-60 HRC
Max Service Temperature:	1100°F
Finishing:	Grind Only
Number of Passes:	3-pass maximum
Current polarity:	DCEP (+)

Diameter	Volts	Amps	Wire Stickout
.035" (0.9mm)	90-150	17-22	1/2"-3/4"
.045" (1.2mm)	180-200	24-28	1/2"-3/4"
1/16" (1.6mm)	190-250	25-28	5/8"-7/8"

PROCEDURE FOR USE

Preparation: Clean weld area of scale and/or oxide. A nominal preheat of 150°F is advised if part is below 40°F or over 1" thick. For higher carbon steels higher preheats will be needed.

Technique: Maintain the optimum electrode stick-out 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 crater-cracking tendencies and potential crater out-gassing.

Post-welding: Allow parts to slow cool in still air.

TYPICAL APPLICATIONS

Earthmoving / Civil Engineering Industries: Ripper shanks, rock rakes, bucket lips and adapters and dragline clevises.

Crushing & Grinding: Rotor and impeller bars, stripper bars grizzly bars and cone crusher rolls.

Cement Industry: Drag chain links, cement chutes, crusher hammers and bowls.

Steel Industry: Coke pusher shoes, clinker belt links, skip cars, and ore discharge chutes.



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



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