

A Unique Bronze Alloy Electrode with Exceptional Weldability

# Xuper®2800 XHD

- May be used with either AC or DC welding machines
- Good color match to bronze alloys
- Deposits are easily machined
- Excellent resistance to corrosion and frictional wear
- Specially formulated coating reduces heat input while increasing deposition rate

## Xuper<sup>®</sup> 2800 XHD

Xuper 2800 XHD is a unique bronze alloy electrode with exceptional weldability for electrodes of this type using AC or DC power sources. Arc drive is strong, but controlled, providing superior arc stability and handling. The electrode can be used to join a wide variety of metal alloys. It produces an excellent bearing deposit that is easily machined to a very smooth, low friction surface. An exclusive alloy formulation helps to de-oxidize the weld deposit. Controlled low penetration and reduced heat input minimize dilution from the base metal.

Deposits have excellent salt water and steam corrosion resistance, making Xuper 2800 XHD particularly applicable to marine and utility applications.

## TECHNICAL DATA

Typical Values		
Tensile Strength:	AC 50,000 psi (345 Mpa) DC 45,000 psi (310 Mpa)	
Hardness:	80 - 85 HRB as deposited 95 HRC work hardened	
Current:	AC or DC (-)	

### SUGGESTED WELDING PARAMETERS:

Diameter	AC	DC
3/32" (2.4mm)	60 - 100	55 - 90
1/8" (3.2mm)	80 - 120	80 - 110
5/32" (4.0mm)	110 - 150	90 - 120
3/16" (4.8mm)	140 - 170	100 - 130

*Note:* Always keep electrodes in their container during storage. Damp electrodes can cause cracking and porosity. For re-drying procedures check with Technical Services.

## PROCEDURE FOR USE

**PREPARATION:** Remove damaged metal and thoroughly clean the weld area of all contaminating debris, oxides, grease, oils, etc. Prepare the joint as appropriate to its composition and dimensions. A preheat of 300° to 500°F (148° to 260°C) is generally recommended for heavy sections and high thermally conductive materials

**TECHNIQUE:** Maintain a medium-to-short arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2 times the electrode diameter) is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit wear properties. The optimum bead width is a stringer bead. Back whip craters to reduce crater-cracking tendencies.

**POST-WELDING:** Allow parts to slow cool in still air. High carbon steels, air hardenable steels and all tool steels should be covered with a heat-retardant blanket to control the cool-down rate.

## TYPICAL APPLICATIONS

- Pump Casings
- Impellers
- Marine Hardware
- Bearing Surfaces
- Casting Salvage
- Joining Dissimilar Metals

Observe normal welding practices, respiratory protection and proper air fl ow pattern advised. For general welding prac-tices, 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 begin-ning 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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