Castolin Eutectic®
Eutectic Castolin

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® 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

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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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