



Ultimate Joining and Cladding Electrode
for Most Industrial Steels

Xuper[®] 6868 XHD



- Ultra-fast, high deposition
- High strength on dissimilar steels
- Excellent for cladding prior to hardfacing
- Composition is very good for joining Carbon and 3xx Stainless Steels

Xuper® 6868 XHD

Xuper 6868 XHD is uniquely formulated for both high strength joining of low-to-medium carbon steels, most 3xx stainless steels and for surface cladding prior to hardfacing. Weld deposits are tough and crack-resistant and will not spall under repeated impacts. This easily handled high deposition electrode does not overheat at the recommended amperage settings.

TECHNICAL DATA

Typical Values	
Tensile Strength:	115,000 psi (795 N/mm ²)
Yield Strength:	85,000 psi (590 N/mm ²)
Elongation (1=5d) min.:	24%
Hardness:	90 HRB
Max. Temperature:	800°F (430°C)

SUGGESTED WELDING PARAMETERS:

Diameter	Amperage
1/16" (1.6mm)	40 - 60
5/64" (2.0mm)	60 - 70
3/32" (2.4mm)	70 - 85
1/8" (3.2mm)	90 - 120
5/32" (4.0mm)	125 - 155

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: Clean weld area of scale and/or oxide. Angle prepping normally involves close-butts and/or bevel preparations. If a joint preparation is needed, a 60° bevel is acceptable. Preheat and inter-pass temperatures will depend on the grade of steel, if known. Known grades should be nominally preheated within a 400-500°F (204-260°C) range.

TECHNIQUE: A short, non-contact technique is recommended for both fillet and butt-welding. Use a slightly longer arc-length for bead-on-plate welding. Deposit stringer beads or 2x to 3x weave beads. Do not weave more than three times the electrode diameter otherwise slag interference will be encountered.

POST-WELDING: Parts that have been preheated should be wrapped or covered with heat-retardant material to help with slow cooling.

TYPICAL APPLICATIONS

APPLICATIONS	INDUSTRY
• Rebuild Parts Prior to Hardfacing	Most Industries
• Mold Repairs	Plastic Manufacturing
• Coal Washing Screens	Mining
• Wear Plate Welding	Most Industries
• Manganese Steel Bucket Lips	Mining
• Bowl Mills	Cement Works
• Hydropurge Rotors	Pulp & Paper

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, 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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