



General Purpose Hardfacing  
Electrode for Abrasion and Impact

# EutecTrode® 5002



- Easy and complete slag removal
- Crack-resistant deposits
- Excellent for field repairs

# 5002

EutecTrode 5002 is a general purpose hardfacing electrode for resistance to abrasion and impact. It is suitable for the surfacing of new or worn machine components used for earthmoving or rock crushing.

## TECHNICAL DATA

### Typical Values

Hardness:	54-58 HRC single pass
Positions:	Flat and Horizontal
Current & Polarity:	AC/DC (+)

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
AMPERAGE	100-140	140-180	180-230

## PROCEDURE FOR USE

**PREPARATION:** Clean the weld area and remove scale and oxide. For parts below 40°F or over 1" thick, preheat to 150°F. Higher carbon steels require higher preheat (300°F - 500°F). Do not preheat Hadfield manganese steel castings above 200°F.

**TECHNIQUE:** Maintain a medium to short arc. The electrode should be inclined at a 15-30° angle in the direction of travel. Weld using stringer beads or 2x weaving. Be advised that weaving more than 2x the electrode diameter is not advised as it may overheat the base metal and degrade weld deposit wear properties. Prior to extinguishing the arc, back whip the craters to reduce crater cracking.

**POST WELDING:** Slow cool parts in still air. High carbon steels and air hardenable steels should be covered with a heat retardant blanket.

## TYPICAL APPLICATIONS

Shredders, Feed Screws, Bucket Teeth, Crushers



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