



High Efficiency Hardfacing Electrode
for Abrasion and Impact

EutecTrode® 6327 XHD



- Ideal for thick, multiple pass coatings without stress relief cracking
- Very resistant against spalling and fatigue cracking in service
- Regular weld bead profile which is virtually spatter free

6327 XHD

High efficiency manual electrode, ideal for maintenance and repair applications or production where weld coatings of the highest quality, performance and productivity are required.

This special alloy formulation precipitates primary and ultra-hard phases of complex carbides (Nb, V, Ti and Cr), finely dispersed within a martensitic matrix with residual austenite. This provides combined resistance against impact and abrasion involving high stresses, even at high temperatures. Weld deposits retain hot hardness properties up to 932°F (500°C.)

TECHNICAL DATA

Typical Values

Hardness as-deposited:	59 HRC
Positions:	Flat and Horizontal
Current & Polarity:	DCEP (+)

DIAMETER	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	90 - 140	125 - 160

PROCEDURE FOR USE

PREPARATION: Completely remove all previous weld deposits or cracked metal with ChamferTrode.

PREHEATING: Preheating depends on the steel's Carbon Equivalent and the workpiece size, thickness and the geometry. Castolin Eutectic recommends:

CE < 0.2: preheating not essential.
CE 0.2 - 0.4: preheating 212° - 392° (100° - 200°C)
CE 0.4 - 0.8: preheating 392° - 662° (200° - 350°C)

Note that 12-14% Mn steels should never be preheated and that the workpiece temperature during welding should be kept below 482°F (250°C).

INTERMEDIATE COAT: On 12-14% Mn steels, weld an intermediate layer.

TECHNIQUE: After arc striking, pull the electrode at an angle of 70-80° to guarantee optimum melting and slag dispersal. If additional passes are required, these should only be executed while the weld is still hot.

POST-WELDING: The weld deposits can be finished by grinding.

TYPICAL APPLICATIONS

Designed for wear-resistant protective coating of carbon steel, alloy steels and austenitic manganese steels.

- Hammers, bars, anvils and casings for crushers
- Teeth and edges of buckets on mechanical diggers
- Teeth and edges of clamshell buckets and dredges
- Drill bits, drilling tools, scrapers, hoppers
- Dredge pump components
- Hot and cold cutting tools
- Tire shredding knives

INDUSTRIES INCLUDE: cement, mining, drilling, quarries, public works and tool & die and recycling.



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