



Quality Low-Hydrogen Electrode
with Welds of X-Ray Integrity

EutecTrode® 66N



- Superior arc stability with virtually spatter-free metal transfer
- Formulation enables all diameters to be operated at lower amperage levels
- Deposits have moderately heavy slag, which is extremely easy to remove

66N

EutecTrode 66N is an all-position electrode with excellent bead control, crack resistance and mechanical properties.

66N is suitable for most carbon and low-alloy steels, including use as a scavenger of “tramp” elements in the welding of high sulfur or phosphorous bearing steels.

TECHNICAL DATA

Typical Values	
Tensile Strength:	85,500 psi
Yield Strength:	73,200 psi
Elongation:	(1=5d) min.: 22%
Current & Polarity:	DCEP (+) or AC (~)

A: Thick Sections, Heavy Build-Up (multi-pass)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
AMPERAGE	75 - 100	120 - 160	170 - 200	230 - 275

B: Thin Sections, Out-of-Position

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
AMPERAGE	55 - 70	100 - 120	140 - 175	N/A

PROCEDURE FOR USE

PREPARATION: Clean all weld surfaces, paying particular attention to removing grease, oil and rust. Prepare joints mechanically or use ExoTrode® surface preparation electrodes to scarf open a nominal 60° “V”. Lightly grind or brush surfaces to remove slag, oxides and debris which might contaminate the weld.

PREHEAT AND INTERPASS TEMPERATURES: Determined from both the carbon and alloy content of the base metal. For some low alloy, high-tensile steels, a preheat of 500° F (260° C) is recommended.

WELDING: Maintain a short to medium arc length and avoid contact welding. Deposit stringer beads of no more than two times the electrode diameter. Back-whip all craters.

Use of Run-off tabs is highly recommended to avoid stop-start porosity and embrittlement, especially on hardenable steels.

TYPICAL APPLICATIONS

- General boiler welding
- Ship hull construction
- Pressure vessels and connections
- Heavy-duty equipment
- Metal-production fabrication



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