Castolin Eutectic®
Eutectic Castolin

A High Efficiency Complex Carbide Hardfacing Electrode

# EutecTrode® N 6060

- Exceptional abrasion resistance
- Excellent weldability
- High efficiency metal recovery
- Contains ultra-hard complex carbides
- Minimal slag residues
- Out-of-position capability

# EutecTrode® N 6060

EutecTrode N 6060 is a high efficiency complex carbide alloy electrode containing controlled percentages of hard constituents producing, extremely hard deposits up to 842°F (450°C).

This alloy produces a deposit of fine metallurgical structure, which gives excellent resistance to abrasion by both fine and coarse mineral particles, particularly the former. Excellent metal recovery rates are obtained. The arc characteristics are of the "spray type" producing smooth, ripple-free deposits.

## TECHNICAL DATA

| Typical Values | |
|---|---|
| **Hardness as-deposited:** | 62-64 HRC |
| **Positions:** | Flat, Horizontal and Vertical Up |
| **Current & polarity:** | AC or DCEP |

**Heavy Sections - High Deposition**

| DIAMETER | 1/8" (3.2mm) | 5/32" (4.0mm) |
|---|---|---|
| AMPERAGE | 155-165 | 205-215 |

**Small Sections - Low Dilution - Low Heat Input**

| DIAMETER | 1/8" (3.2mm) | 5/32" (4.0mm) |
|---|---|---|
| AMPERAGE | 100-140 | 120-180 |

## PROCEDURE FOR USE

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

**PREHEATING:** Preheating will depend upon type, size and carbon equivalent of the base material. A general guide: steels with a carbon equivalent of up to 0.25% no pre-heat needed. For steels between 0.25% and 0.45% carbon equivalent, pre-heat between 212°F - 482°F (100°C - 250°C). Steels above 0.45%, preheat between 482°F - 662°F (250°C - 350°C).
**Do not preheat austenitic manganese steels.**

**TECHNIQUE:** Select lowest possible amperage setting from the recommended range when depositing directly to the base material. EutecTrode 680 may be used as initial or intermediate layers especially on large or heavy build-up applications. For applications where impact and pressure is present, deposit into pre-prepared grooves at a pitch not less than the width of the groove (two layers should be deposited into the grooves).

Maintain an arc length equal to the electrode diameter and a near vertical electrode angle. Limit each deposit length between 2" - 4" (50-100 mm).

**POST-WELDING:** Safely stack and store electrodes in a dry location. If electrodes have absorbed moisture, the following re-drying conditions before use are recommended: 350°F (150°C) / 1-2 hr.

## TYPICAL APPLICATIONS

For protecting components against abrasion and erosion, especially where both fine and coarse grain mineral particles are present. Suitable for a wide range of steels including medium carbon steel, low alloy steels and austenitic manganese steels.

- Excavation tools, pocket-bins, bucket edges
- Extrusion screws
- Mineral, sand and gravel processing equipment
- Mixing blades and scrapers

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