



Anti-Wear Continuous Open Arc Wire

# **TeroMatec®**

## **0A 4660**



- Ideal choice for field work or on-site applications
- No need for costly gas cylinders or regulators
- Excellent wear protective coating
- Relatively thick, wide overlays possible in a single pass

# TeroMatec® OA 4660

Special, self shielded, flux cored alloy wire specifically developed for outdoor maintenance and repair welding of thick, heavy components where faster weld deposition rates over traditional coated electrodes, are required. Worn or new critical parts may be cost effectively Terocote protected either manually or fully automatically to extend their useful service life and increase productivity and profitability.

High chromium, columbium hyper-eutectic iron-based alloy depositing complex carbides for wear-protective coating of carbon steels, low or high alloy steels and 14% Mn steels. Excellent resistance to severe abrasion and erosion up to 840°F (450°C) service temperatures. Dual pass capability for optimum properties. Ready formation of stress relieving cracks to minimize distortion. Deposits are grindable and rust resistant.

Ideal choice for field work or on site applications. No need for costly gas cylinders or regulators. Core deoxidizers tolerate air currents or draft effects. Relatively thick, wide overlays possible in single pass. No enforced stop - starts increase welding duty cycles.

## TECHNICAL DATA

Typical Values	
Hardness:	63 HRC
Current polarity:	(+) DCEP

Range*	AMPERAGE	VOLTAGE	Stick-Out
A	50-120	19-25	1-1½
B	120-200	24-30	1-1½

\*A: for thin sections, low dilution; B: for thick sections, high deposition

## PROCEDURE FOR USE

**Preparation:** Remove any previous weld deposits or cracked metal with ChamferTrode.

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

CE < 0.2: preheat not essential

CE 0.2 - 0.4: preheat 210°-390°F (approx. 100-200°C)

CE 0.4 - 0.8: preheat 390°-660°F (approx. 200-350°C)

Note that 12-14% Mn steels should never be preheated and the workpiece temperature during welding should be kept below 480°F (250°C) to avoid embrittlement.

**Intermediate Layer:** On 12-14% Mn steels, deposit intermediate layers with TeroMatec 3205 or with the manual electrode EutecTrode 40.

On hardenable and air-hardening steels, deposit intermediate layers with Xuper 6868 XHD. To build up missing sections on low-alloy steels, TeroMatec 2020 is recommended.

**Welding Technique:** After striking, maintain the wire stick-out around 1.5" (40mm) with an arc length approx. 0.25" (7mm). Longer wire stick-out will further increase deposition rates. For optimum deposit quality, use drag stringer bead or moderate weaving techniques to minimize overheating risks. Stop welding by rapidly lifting the wire away from the work piece.

## TYPICAL APPLICATIONS

For wear-preventive protective coating of a wide range of steel components subject to severe abrasion or erosion by mineral particles, sand, rocks, gravel etc. processed in the Quarry, Earthmoving, Dredging, Sand/ Gravel, Coal/ Coke and Cement industries: Wear plates, pneumatic conveyor systems, mixer blades, pump impellers, mold screws, coal screens, excavator bucket teeth, conveyor chutes, sand pumps, concrete mixers, asphalt handling etc.



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