

Multi-Carbide Hardfacing Electrode

AbraTec® 6715 XHD



WELDING

- Exceptional wear resistance against high temperature abrasion
- Achieves final hardness in a single pass
- Deposit hardness attained with a refined mix of primary and secondary carbides
- Welds with a deposition rate double that of conventional electrodes with minimum slag



DESCRIPTION:

AbraTec 6715 XHD is a multi-carbide electrode that deposits smooth weld beads and is easily handled, especially in the flat position. The mix of primary and secondary carbides renders deposits that are resistant to high temperature abrasion up to 1,200°F. 6715 XHD provides a single pass hardness of HRC 65. Can be used on carbon steels, low alloy steels, manganese steel castings and AR plate.

TYPICAL APPLICATIONS:

APPLICATIONS

Coal Burner Nozzles
Coke Pusher Shoes
Clinker Grinders
Sinter Equipment
Conveyor Screw
Pug Mill Knives

INDUSTRY

Thermal Power Plants
Iron & Steel / Concrete
Cement Works
Iron & Steel Works
Brick & Clay
Raw Material Processing

TECHNICAL DATA:

Hardness as-deposited: HRC 64-66

Carbide Hardness: VPN 1250 - 1400 (M_7C_3)*

Maximum Service Temperature: 1200°F

Welding Parameters

Current & Polarity: AC or DCEN/P (-/+)**

**Note: The "M" stands for Cr-W-Cb-Mo*

***DCEP increases dilution and ductility. Recommended for impact applications. HRC 63-65. DCEN results in less dilution Recommended for sliding abrasion applications. HRC 65-68.*

Diameter	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
Amperage	160-240	180-270	230-375

TYPICAL WELDING PROCEDURE

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 preheats (300°F - 500°F). Do not preheat Hadfield manganese steel castings above 400°F.

Technique: Maintain a medium to short arc. The electrode should be inclined at a 45° angle in the direction of travel. Weld using stringers or 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.



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