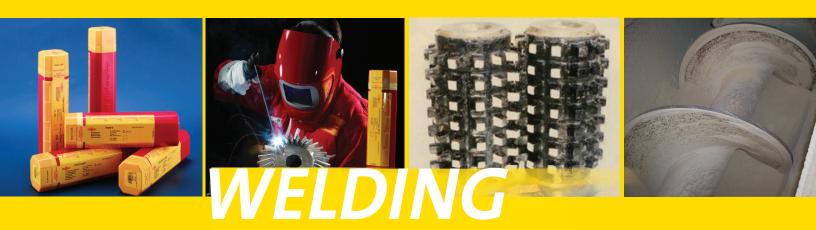
# AbraTec 6715 XHD



- 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 INDUSTRY

Coal Burner Nozzles Thermal Power Plants
Coke Pusher Shoes Iron & Steel / Concrete
Clinker Grinders Cement Works
Sinter Equipment Iron & Steel Works
Conveyor Screw Brick & Clay
Pug Mill Knives Raw Material Processing

## **TECHNICAL DATA:**

Hardness as-deposited: HRC 64-66 Carbide Hardness: VPN 1250 - 1400 (M<sub>7</sub>C<sub>3</sub>)\* 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. Reccomended for impact applications. HRC 63-65. DCEN results in less dilution Reccomended 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



# KM WELDCO SDN BHD (1504932-M)

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#### **EUTECTIC CANADA**

TYPICAL WELDING PROCEDURE

the craters to reduce crater cracking.

above 400°F.

retardant blanket

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

**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

Post-Welding: Slow cool parts in still air. High carbon steels

and air hardenable steels should be covered with a heat

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