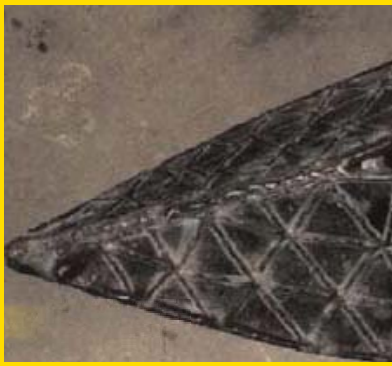
Multi-Carbide Hardfacing Electrode

AbraTec® 6710 XHD



WELDING

- Exceptional wear resistance to grinding abrasion and particulate erosion
- 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

Castolin Eutectic®
Eutectic Castolin

DESCRIPTION:

AbraTec 6710XHD is an easily handled multi-carbide electrode formulated to deposit smooth weld beads at an especially high rate. The mix of primary and secondary carbides render deposits that are resistant to high pressure abrasion and particle erosion at temperatures up to 1,000 °F. 6710XHD provides a single pass hardness of HRC 64. Can be used on carbon steels, low alloy steels, manganese steel castings and AR plate.

TYPICAL APPLICATIONS:

APPLICATIONS	INDUSTRY
Dragline Bucket Parts	Mining
Conveyor Chains	Cement Works
Mixer Paddles	Concrete
Sludge Pumps	Oil & Gas Extraction
Manganese Steel Castings	Railroad / Mining
AR Plate Weld Reinforcement	Various Industries

TECHNICAL DATA:

Hardness as-deposited: HRC 63-65
Carbide Hardness: VPN 1200 - 1300 (M_7C_3)*
Maximum Service Temperature: 1000°F
Welding Parameters
Current & Polarity: AC or DCEN (-)

Diameter	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)	1/4" (6.0mm)
Amperage	120-190	170-230	220-290	300-450

**"M" stands for Cr-W-Cb-Mo indicating a complex of mixed, wear-reducing carbides.*

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.

KM WELDCO SDN BHD (1504932-M)
No.46, Jalan Apollo U5/191,
Bandar Pinggiran Subang, Seksyen U5,
40150 Shah Alam, Selangor D.E., Malaysia.
Tel: +603 - 7490 2031
website: www.kmweldo.com.my
email: enquiry@kmweldco.com.my

YOUR RESOURCE FOR PROTECTION, REPAIR AND JOINING SOLUTIONS

Castolin Eutectic® Eutectic Castolin

Eutectic Corporation
N94 W14355 Garwin Mace Drive
Menomonee Falls, WI 53051 USA
P 800-558-8524 • F 262-255-5542
www.eutectic.com

Eutectic Services
12300 Carmen Avenue
Milwaukee, WI 53225 USA
P 800-558-8524 • F 262-255-5542