

Unique Chromium-Carbide Bearing Electrode with Superior Abrasion  
and Impact Properties

# ChromCarb® N6006



## WELDING

- For use on most carbon, low-alloy and manganese steels
- Resistant to coarse particle abrasion with moderate impact
- Provides dense, smooth, easy to clean deposits



## DESCRIPTION:

ChromCarb N6006 is an electrode for the overlay and protection of carbon, alloy and manganese steels. A high chromium carbide content makes it especially favorable against coarse particle abrasion, moderate gouging impact and mild corrosion in any number of service conditions.

## TYPICAL APPLICATIONS:

- Muller tires
- Anvils
- Dredger parts
- Bucket arms
- Pug mill paddles

## TECHNICAL DATA:

Typical Hardness: 57-60 HRC (as deposited)  
Typical Carbide Hardness: 1200 (Cr<sub>7</sub>C<sub>3</sub>) VPN  
Current & Polarity: DCEP (+) or AC

### Availability and Recommended Amperages

Dia.	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
Amp.	90-130	120-160	150-210

## WELDING PARAMETERS:

**Preparation:** Clean weld area of scale and/or oxide. A nominal preheat of 150°F is advised if part is below 40°F or over 1" thick. For higher carbon steels higher preheats will be needed. Check the Reference Section for information regarding specific preheating levels for specific steel grades.

**Note:** *Do not preheat Hadfield manganese steel castings above 400°F as this will cause time-temperature embrittlement.*

**Technique:** For base metals with high hardenability a buffer layer is highly recommended prior to application of ChromCarb N6006. For Manganese steels, use EutecTrode 40; for air-hardenable steels, use EutecTrode 680 and for cast irons, Xuper 2233N. Only one pass of ChromCarb N6006 should be used on cast irons.

Maintain a medium arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2 times the electrode diameter) is not advised as wide beads can cause excessive base metal overheating and degrade the weld deposit wear properties. Back whip craters to reduce crater-cracking tendencies.

**Post-welding:** Allow parts to slow cool in still air. High carbon steels and air hardenable steels should be covered with a heat-retardant blanket.



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