

Superior Chromium Carbide Hardfacing Electrode

EutecTrode® 4004N



WELDING

- Excellent weldability in all positions on all carbon and alloyed steels, manganese and cast irons
- Maximum wear resistance for applications involving abrasion and abrasion plus impact
- High concentration of wear-resisting chromium carbides



DESCRIPTION:

EutecTrode 4004N weld deposits are ideal for combating general abrasion when impact is expected. Deposits polish in service to further reduce the rate of wear. A unique matrix further imparts high compressive strength to resist in-service spalling.

TYPICAL APPLICATIONS:

Augers
Crusher liners
Scrapers
Dredge pumps
Dipperteeth/lips
Muller tires
Anvils
Dredger parts
Bucket arms
Pug mill paddles
Impactor bars
Tamper tips
Pusher shoes
Auger bits
Ore chutes

TECHNICAL DATA:

Hardness as-deposited: Rockwell C 55-60
Carbide Hardness (VPN): ~1200 (Cr7C3)
Carbide % avg. count: Medium-to-High
Current & Polarity: DCEP (+) and AC

Diameter	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
Amperage	120-150	130-170	170-230

TYPICAL WELDING PROCEDURE

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 of the Eutectic Product Data Book for information regarding specific preheating levels for special steel grades.

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

Technique: Maintain a medium arc and incline the electrode at a 45° angle in the direction of travel. Excessive weaving (more than 2 x 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 cratercracking 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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