

ESSEN® N 6006

AC/ DC +

Special Product

An IMPROVED Electrode having Excellent Resistance to Impact, Abrasion, Corrosion, Heat, Cavitation etc.



PROPERTIES

Essen N 6006 is an IMPROVED electrode having excellent resistance to Impact, Abrasion, Corrosion, Heat, Cavitation etc.

MECHANICAL PROPERTIES

Hardness
57-60 Hrc

APPLICATIONS

ESSEN 6006 has been specifically designed for use in Mining, Cement & Sugar Industries for the surfacing of Knives, Hammers and wear areas. It can however, be used in a variety of applications, which include the surfacing of excavator bucket lips and teeth, drag line buckets, screw conveyors, rock chutes thrash plate and scraper plate teeth etc. Also for number of applications in Steel, Power, Cement, Paper and Mining Industries.

WELDING PROCEDURE

No preheating is required when the carbon equivalent of the material to be surfaced is below 0.3 (i.e. steels having low carbon and manganese content with no alloying elements). The amperage should be kept as low as possible to obtain satisfactory bead profile. Relief checks are normal, but can be aggravated by using low currents and high travel speeds. For maximum effect the beads should be arranged to 90 degrees to the working direction where possible

RECOMMENDED AMPERAGE	
Size	Current
3.15 mm x 350 mm	120 - 160 Amps
4.00 mm x 350 mm	130 - 180 Amps

PACKING	
3.15 mm x 350 mm 5 kg	20 pcs/kg (Approx.)
4.00 mm x 350 mm 5kg	14 pcs/kg (Approx.)



ESSEN
WELDING ALLOYS PVT. LTD.



ESSEN & AZUCAR
PREMIUM WELDING ALLOYS

ESSEN® PRODUCTS ARE MANUFACTURED AND SUPPLIED
ESSEN WELDING ALLOYS PVT. LTD. PUNE, INDIA,
TM REGISTERED IN INDIA BY: M/S. ASUGAR ENGINEERS PVT. LTD.
PUNE, VIDE REGD. T.M. NO. 543993 B.

'Sai maa', Post : Kadam Wak Wasti via Loni Kalbhor, Post P. B. No.1, Tal.: Haveli,
Dist.: Pune 412201, INDIA TEL: +91 -20 -65781493, 26911175 26911029 FAX: +91-20-26911030
Email: asugar@pn3.vsnl.net.in / essenelectrode@vsnl.net.in
Website: essenelectrode.com