

EutecTrode 6666

Metals And Welding Specialities Supplying to over 40+ countries including USA, Europe, Middle East, Asia.



[EutecTrode 6666](#) is a hardfacing welding electrode of outstanding performance that yields great resistance to abrasion, impact, and metal-to-metal wear. It is a great resource for rebuilding and protecting parts that operate in very harsh conditions, Because of this extending the equipment life and lowering the maintenance costs. The weld deposit has not only high hardness but also great durability and Because of this can be used for the restoration of damaged surfaces as well as for increasing the efficiency of industrial machinery.

Such electrodes find their main application in mining, cement production construction steel production, and material handling. For hard facing crusher parts, excavator buckets, conveyor components, earthmoving equipment, and other wear-prone machinery, EutecTrode 6666 hard facing welding electrodes come as the perfect solution. Their exceptional welding properties, strong bonding ability, and long-lasting wear resistance have made them a favored choice for maintenance and repair purposes where durability and productivity matter a lot.



Metals And Welding Specialities, we offer superior grade [EutecTrode 6666 Welding Electrodes](#) that are strong, dependable, and offer excellent wear resistance and long service life in heavy usage industrial environments. We uphold high standards of quality while giving customers competitive prices, having products in stock ready for sale, and delivering them on time so that customers get the right welding products when they need them. We share with our customers the deep understanding of the marine and offshore industries, support in choosing the correct welding products for their specific applications, and providing excellent customer service which are key factors helping those businesses to make their equipments more durable, bring maintenance costs down, and have stable welding results for different hardfacing and repair applications.

Specification EutecTrode 6666 Welding Electrodes

Specification	Detail
Product name	EutecTrode 6666
Manufacturer / Brand	Castolin Eutectic (EutecTrode)
Electrode type	Double-coated manual (coated stick) electrode
Coating characteristics	Combination of basic and rutile characteristics (double coating)
Classification	DIN EN ISO 2560-A: E 38 2 B 12 H 10; AWS A5.1: E7016
Typical diameters	2.4 mm, 3.2 mm, 4.0 mm (common sizes)
Current	Suitable for AC and DC welding
Welding positions	All-position capable (good suitability for constrained / out-of-position work)
Permissible operating temperature	From -20 °C up to +350 °C
Key features	Low heat input; stable arc and fine droplet transfer; low spatter; easily removable slag; reinforced bead profile; good impact/toughness at sub-zero temps
Typical applications	Joining structural and low-alloy steels (machine frames, supports, high-pressure pipes, flanges, heavy stressed joints)

Equivalent Grade Of EutecTrode 6666 Welding Electrodes

Standard / Specification	Equivalent / Classification
Castolin / internal	Wire equivalent: EnDOtec DO65
DIN EN ISO 2560-A	E 38 2 B 12 H 10
AWS A5.1	E7016

EutecTrode 6666 Welding Electrodes Parameters

Parameter	Value / Range
Tensile Strength (Rm)	~ 82,000 psi (~ 565 MPa)
Yield Strength	~ 61,000 psi (~ 420-462 MPa)
Elongation (L = 5 d)	~ 25 %
Impact Strength (Charpy / ISO-V)	104 ft·lb @ 68 °F (~ 140 J @ 20 °C) 59 ft·lb @ 0 °F (~ 80 J @ -20 °C) > 47 J @ -60 °C
Service Temperature Range	-60 °C to 350 °C
Electrode Diameters	2.5 mm, 3.2 mm, 4.0 mm, 5.0 mm
Welding Current / Amperage Ranges	2.5 mm → 70-90 A 3.2 mm → 100-130 A 4.0 mm → 130-170 A 5.0 mm → 140-190 A
Recommended Polarity / Current Type	DCEP / AC
Coating Type	Double (bipheric) coating, hydrogen-controlled, dual flux layers
Low Heat Input Feature	Yes

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