

Metals And Welding Specialities presents the EutecTrode 6800 Welding Electrodes, engineered to deliver dependable performance in demanding overlay, build-up, and repair environments. As a high-nickel alloy manual electrode, EutecTrode 6800 offers a robust solution for corrosion resistance, thermal shock durability, and wear protection for components exposed to extreme conditions. Under its nominal classification, this electrode corresponds to UNS N06680 and aligns with the ASTM Grade Ni-6800 chemistry in the universal nickel alloy electrode family (often referenced simply as “Universal Standard 6800”).



Table Of Content

- [What is EutecTrode 6800 Welding Electrodes?](#)
- [Specification of EutecTrode 6800 Welding Electrodes](#)
- [Equivalent Grade Of EutecTrode 6800 Welding Electrodes](#)
- [Chemical Composition of EutecTrode 6800 Welding Electrodes](#)
- [EutecTrode 6800 Welding Electrodes Parameters](#)
- [People Searched for EutecTrode 6800 Welding Electrodes](#)
- [Supply Cities of EutecTrode 6800 Welding Electrodes](#)
- [Export Countries of EutecTrode 6800 Welding Electrodes](#)

The EutecTrode 6800 electrode is designed to operate with AC or DC reverse polarity, enabling stable arc control and minimal overheating risk even at elevated temperatures. It is ideally suited for overlaying or joining nickel-based alloys to steels, ensuring low dilution and strong metallurgical bonding. Its weld deposits remain machinable, exhibit excellent oxidation and corrosion resistance, and yield hardness values that strengthen under impact conditions—starting at about 210 BHN in the as-deposited state and working higher under service—providing both toughness and wear resilience.



EutecTrode 6800 Welding Electrodes, EutecTrode 6800 Welding Electrodes Manufacturers, EutecTrode 6800 Welding Electrodes Suppliers, EutecTrode 6800 Welding Electrodes Stockists, EutecTrode 6800 Welding Electrodes Exporters

Metals And Welding Specialities positions this electrode for critical applications such as rebuilding worn forging and stamping dies, protective coating for chemical mixer components, plating tanks, valve internals, pump casings, and hot cutting blades, where thermal cycles and corrosive media are prevalent. The coating resists deformation even at temperatures approaching 926 °C (1700 °F), making it a dependable choice for high-temperature overlay tasks.

In practice, welders should maintain a close arc, use stringer bead techniques for high-alloy overlay, and carefully back-whip craters to manage heat input. Preheat is generally unnecessary unless handling thick sections. Proper slag removal and controlled cooling are essential to preserve deposit integrity and avoid distortion.



EutecTrode 6800 Welding Electrodes in India, EutecTrode 6800 Welding Electrodes Manufacturers in India, EutecTrode 6800 Welding Electrodes Suppliers in India, EutecTrode 6800 Welding Electrodes Stockists in India, EutecTrode 6800 Welding Electrodes Exporters in India

By choosing EutecTrode 6800 from Metals And Welding Specialities, clients benefit from expertly controlled alloy chemistry, consistent quality, and full technical support. Whether you are repairing dies in hot forging, fabricating components exposed to corrosive atmospheres, or joining nickel-based parts to steel substrates, this electrode stands as a reliable, versatile option with excellent deposit consistency and service life extension.

Specification EutecTrode 6800 Welding Electrodes



Specification	Details
Product Name	EutecTrode® 6800
Manufacturer / Brand	Castolin Eutectic (Eutectic Technologies)
Electrode Type	Coated manual stick electrode (SMAW)
Alloy / Deposit	High-nickel alloy deposit (nickel-based maintenance/overlay alloy)
Primary Properties	Good resistance to heat & corrosion; impact-wear increases hardness; creep-resistant; easily machinable
Typical Applications	Overlay/buildup and joining of nickel & steel alloys; hot cutting blades; forging & stamping dies; chemical mixers; pumps & valves
Typical Base Metals	Carbon steels, low/medium alloy steels, nickel-based alloys, stainless steels, gray & alloyed cast irons
Welding Current / Polarity	AC or DC+ (recommended DC+ for many applications)
Common Diameters (typ.)	3/32" (2.4 mm), 1/8" (3.2 mm)
Packaging Examples	Plastic container baskets (vendor packages; e.g., 11 lb containers shown by some distributors)

Typical Procedure Notes

Hold a close arc; back-whip craters; remove slag between passes

Equivalent Grade Of EutecTrode 6800 Welding Electrodes



Brand	AWS Classification	EN ISO	DIN Standard	Werkstoff No.	UTP	Böhler	ESAB	Lincoln Electric	Thermanit
EutecTrode 6800	E312-16	E 29 9 R 1 2	E Z 29 9	1.4337	UTP 68 HC	FOX CN 29/9	OK 68.81	Wearshield ME	Thermanit 680

EutecTrode 6800 Welding Electrodes Parameters



Parameter	Value
Product name	Xuper / NucleoTec N 2222 (Nucleotec 2222)
Classification	AWS A5.11: E NiCrFe-3 · EN ISO 14172: E Ni 6182 · W.Nr. 2.4807
Hardness (as-deposited)	≈ 90 HRB
Tensile strength (typical)	94,000–100,000 psi (650–690 N/mm ²)
Yield strength (typical)	≈ 56,565 psi (390 N/mm ²)
Elongation (l = 5d)	≈ 45%
Impact strength	96 ft·lb (130 J) @ 68°F (20°C)
Current polarity	DC Reverse
Welding positions	All positions
Typical/base metals	All steels & nickel alloys, difficult-to-weld steels, clad steels, cryogenic steels, mold steels, specialty steels
Typical applications	Maintenance & repair of high-alloy steels: cryogenic equipment, kiln tyres, furnace parts, chemical processing equipment, heat-exchange equipment, injection molds, forging tools, heavy cross-sections
Available diameters	3/32" (2.4 mm), 1/8" (3.2 mm), 5/32" (4.0 mm), 3/16" (4.8 mm)
Recommended amperage — thick sections / heavy build-up	3/32" (2.4 mm): 80–90 A · 1/8" (3.2 mm): 100–110 A · 5/32" (4.0 mm): 120–140 A · 3/16" (4.8 mm): 150–170 A
Recommended amperage — thin sections / out-of-position	3/32" (2.4 mm): 50–70 A · 1/8" (3.2 mm): 70–90 A · 5/32" (4.0 mm): 90–110 A · 3/16" (4.8 mm): 110–140 A

People Also Searched

ASTM A240 Grade 2222 electrodes, UNS S22222 welding rods, stainless steel coated electrodes, low hydrogen welding electrodes, high strength welding electrodes, flux-coated electrodes, pressure vessel welding rods, all-position electrodes, arc

welding consumables, structural steel welding electrodes, corrosion-resistant welding rods, high-tensile electrodes, industrial welding supplies, stainless steel filler metals, shielded metal arc electrodes, hydrogen-controlled electrodes, pipe welding rods, shipbuilding electrodes, power plant welding rods, petrochemical welding consumables, precision welding electrodes, SMAW electrodes, metal fabrication electrodes, heavy-duty welding electrodes, alloy steel electrodes, repair welding rods, overlay welding electrodes, maintenance welding electrodes, AWS classified electrodes, premium coated welding rods, stable arc electrodes, weld bead control rods, slag removal electrodes, industrial arc welding rods, mechanical strength electrodes, durable welding consumables, and performance welding electrodes.