

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 1215 ELECTRODE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 1215 Electrode is a smooth running rutile coated stick electrode with an AISI A-2 air hardening chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka 1215 Electrodes are a AISI A-2 air hardening tool steel alloy. The as welded hardness of the deposits will typically be 55–60 HRC which can be tempered to lower hardness when necessary. This alloy has good wear resistance and moderate impact resistance.

RECOMMENDED APPLICATIONS

Eureka 1215 Electrodes are recommended for welding AISI A-2 air hardening tool steels and other air hardening grades. Typical applications encountered are trim steels, piercing punches, flange, and forming dies as well as some draw form operations. This alloy is most widely used for general repair of the air hardening grades and AISI D-2 where a complete heat treat cycle will be used.

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WELDING PARAMETERS

SIZE	AMPERAGE RANGE
3/32" 2.4mm	70 – 120
1/8" 3.2mm	100 – 140
5/32" 4.0mm	140 – 170
3/16" 4.8mm	170 – 225
1/4" 6.35mm	225 – 300
5/16" 7.94mm	300 – 375
3/8" 9.5mm	350 – 425

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo	V
1.0	.50	.25	5.0	1.2	.35

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

55-60 HRC

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TEMPERING DATA

The tempering data is to be used as a guide. Your results may differ due to the many variables in the utilization of this product.

SINGLE TEMPER CURVE EUREKA 1215

