

# Eureka Welding Alloys

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## TECHNICAL DATA FOR EUREKA 1215 SOLID MIG WIRE

**Dated:** March 31, 1995

**Revised:** July 8, 2013

## INTRODUCTION

**Eureka 1215 Solid MIG Wires** are drawn, cleaned, spooled and packaged to obtain smooth wire feeding with a stable spatter free arc. These wires are designed for the most critical applications where weld metal cleanliness is most important.

## METALLURGICAL CHARACTERISTICS

**Eureka 1215 Solid MIG Wires** 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 Solid MIG Wires** 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	VOLTS
.035" 1.0mm	100 – 225	14 – 28
.045" 1.2mm	125 – 250	16 – 28
1/16" 1.6mm	180 – 400	22 – 33

Use DC Current with a Stick Out of  
1/4" - 1 1/4" (6mm-32mm)

## RECOMMENDED SHIELDING GASES

75% Argon, 25% Co2

90% Argon, 10% Co2

92% Argon, 8% Co2

100% CO2 may produce lower quality arc conditions

## GAS FLOW RATE

20-60 CFH

## 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

