

# Eureka Welding Alloys

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## TECHNICAL DATA FOR EUREKA 1215 TIG RODS

**Dated:** March 31, 1995

**Revised:** July 8, 2013

## INTRODUCTION

**Eureka 1215 TIG Rods** are drawn, straightened, cut to length, and then cleaned and packaged to obtain microscopically clean weld deposits. These rods are designed for the most critical applications where weld metal cleanliness is most important.

## METALLURGICAL CHARACTERISTICS

**Eureka 1215 TIG Rods** 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 TIG Rods** 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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## **RECOMMENDED SHIELDING GASES**

**100% Argon**

## **GAS FLOW RATE**

**20-40 CFH**

## **TYPICAL CHEMISTRY**

| <b>C</b>   | <b>Mn</b>  | <b>Si</b>  | <b>Cr</b>  | <b>Mo</b>  | <b>V</b>   |
|------------|------------|------------|------------|------------|------------|
| <b>1.0</b> | <b>.50</b> | <b>.25</b> | <b>5.0</b> | <b>1.2</b> | <b>.35</b> |

## **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

