

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 1216 METAL CORED WIRE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 1216 Metal Cored Wire is a high speed tool steel filler metal. The wire has a smooth spray transfer arc with nearly no slag to contend with. The wire is formulated to develop high quality weld deposits that are porous and crack free. The wire is designed for multi-pass welding which greatly increases productivity.

METALLURGICAL CHARACTERISTICS

Eureka 1216 Metal Cored Wire is a high speed steel filler metal. The wire has a smooth spray transfer arc with a thin slag system that is easily removable. The wire is formulated to develop high quality weld deposits that are porous and crack free. The wire is designed for multi-pass welding which greatly increases productivity.

RECOMMENDED APPLICATIONS

Eureka 1216 Metal Cored wire is recommended for welding AISI M-2 molybdenum high speed steel tools and other high speed tool steel grades. Typical applications encountered are trim steels, piercing punches, broaches, reamers, knives, drills, taps and shears. **Eureka 1216** is utilized in mainly high wear areas and also used on AISI D-2 where a complete heat treat cycle will be used.

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WELDING PARAMETERS

TYPE	SIZE	AMPERAGE	VOLTS
Metal Cored Wire	.045" 1.2 mm	125 – 225	16 – 28
Metal Cored Wire	1/16" 1.6mm	180 – 400	25 – 33
Flux Cored Wire	1/16" 1.6mm	180 – 400	25 – 33
Flux Cored Wire	3/32" 2.4mm	350 – 600	27 – 35
Flux Cored Wire	1/8" 3.2mm	500 – 900	30 – 38

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 will produce low quality arc conditions

GAS FLOW RATE

.045" 1.2 mm 20-50 CFH

1/16" 1.6mm 30-60 CFH

3/32" 2.4mm 80-120 CFH

1/8" 3.2mm 80-120 CFH

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo	W	V
.85	.30	.30	4.3	5.0	6.2	2.0

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PHYSICAL AND OR MECHANICAL PROPERTIES

Welded Hardness

55-60 HRC

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 1216

