

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 130 SOLID MIG WIRE

Dated: March 31, 1995

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INTRODUCTION

Eureka 130 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 130 Solid MIG Wire is a AISI type 4130 low alloy steel. The as welded hardness of the deposits are typically around 35-40 HRC. The hardness is highly dependent on preheat temperature, length of time welding, and cooling rate.

RECOMMENDED APPLICATIONS

Eureka 130 Solid MIG Wire is for welding 4100 or 4300 series steels such as stamping dies, cast steels, plastic molds and composite dies. It is also used for overlaying and build-up of certain types of rolls and other components that must be hardened.

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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
.30	.50	.25	1.0	.20

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PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

35-40 HRC

FULLY HARDENED

50-55 HRC