

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 130 TIG RODS

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INTRODUCTION

Eureka 130 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 130 TIG Rods 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 TIG Rods 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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RECOMMENDED SHIELDING GASES

100% Argon

GAS FLOW RATE

20-40 CFH

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo
.30	.50	.25	1.0	.20

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

35-40 HRC

FULLY HARDENED

50-55 HRC