

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 140 ELECTRODE

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INTRODUCTION

Eureka 140 Electrode is a smooth running rutile coated stick electrode with an 4140 chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka 140 Electrodes is a AISI type 4140 low alloy steel. The as welded hardness of the deposits are typically around 35-45 HRC. The hardness is highly dependent on preheat temperature and length of time welding (cooling rate).

RECOMMENDED APPLICATIONS

Eureka 140 Electrodes 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 RANGE
3/32" 2.4mm	70 – 120
1/8" 3.2mm	100 – 140
5/32" 4.0mm	140 – 170
3/16" 4.8mm	170 – 225
1/4" 6.35mm	225 – 300
5/16" 7.94mm	300 – 375
3/8" 9.5mm	350 – 425

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo
.40	.50	.25	1.0	.20

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

35-45 HRC

FULLY HARDENED

50-55 HRC