

# Eureka Welding Alloys

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## TECHNICAL DATA FOR EUREKA 145 ELECTRODE

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## INTRODUCTION

**Eureka 145 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 145 Electrodes** is a AISI type 6150 low alloy steel. The as welded hardness of the deposits are typically around 42-48 HRC. The hardness is highly dependent on preheat temperature and length of time welding (cooling rate).

## RECOMMENDED APPLICATIONS

**Eureka 145 Electrodes** is for welding 6100 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	V
.50	.50	.25	1.0	.20	.15

## PHYSICAL AND OR MECHANICAL PROPERTIES

### AS WELDED HARDNESS

42-48 HRC

### FULLY HARDENED

55-60 HRC