

# Eureka Welding Alloys

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## TECHNICAL DATA FOR EUREKA 240 ELECTRODE

**Dated:** March 31, 1995

**Revised:** July 8, 2013

## INTRODUCTION

**Eureka 240 Electrode** is a smooth running rutile coated stick electrode with a 309 chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

## METALLURGICAL CHARACTERISTICS

**Eureka 240 Electrodes** weld deposits are of the non-heat treatable austenitic stainless steel variety. This alloy resists scaling up to 1900 °F. The deposits take high polish which creates an anti-frictional surface and will work harden rapidly up to 240 Brinnell when peened. The high Chromium and Nickel contents are extremely resistance to corrosive environments.

## RECOMMENDED APPLICATIONS

**Eureka 240 Electrodes** are for welding A.I.S.I. type 308, 309, and 316 stainless steels. They are also excellent for the repair of joining of furnace parts, bearing surfaces, billet hooks, forging tongs, zinc die casting dies, and drawing and forming dies.

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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	Ni
.02	1.5	.50	24.0	13.0

## PHYSICAL AND OR MECHANICAL PROPERTIES

**TENSILE STRENGTH** 84,000 psi

**YIELD STRENGTH** 60,000 psi

**ELONGATION** 34%