

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 240 SOLID MIG WIRE

Dated: March 31, 1995

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INTRODUCTION

Eureka 240 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 240 Solid MIG Wires weld deposits are of the non-heat treatable austenitic stainless steel variety. This alloy resists scaling up to 1900F. 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 Solid MIG Wires 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 | 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 | 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%