

Eureka Welding Alloys

2000 E. Avis Drive

Madison Heights, MI 48071

Phone: 248-588-0001 Fax: 248-585-7711 Toll Free: 800-962-8560

E-mail: info@eurekaweldingalloys.com Website: www.eurekaweldingalloys.com

TECHNICAL DATA FOR EUREKA 27 ELECTRODES

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INTRODUCTION

Eureka 27 Electrode is a premium quality low hydrogen iron powder all position stick electrode, A.W.S. classification 7018-A1. This electrode exhibits outstanding arc stability with a rapid freezing slag system that is self-detaching. When used in the overhead position the deposits are uniform and no spatter is present to impair the welder.

METALLURGICAL CHARACTERISTICS

Eureka 27 Electrode has typical tensile strength of 85,000 P.S.I. and exhibits excellent low temperature impact properties.

RECOMMENDED APPLICATIONS

Eureka 27 Electrode is used in the general fabrication or joining of structural steels, pipes, plates, and pressure vessels.

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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	Mo
.08	1.9	.60	.50

PHYSICAL AND OR MECHANICAL PROPERTIES

TENSILE STRENGTH 85,000 psi

YIELD STRENGTH 74,000 psi

ELONGATION 28%