

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 28 ELECTRODES

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INTRODUCTION

Eureka 28 Electrode is a premium quality low hydrogen iron powder all position stick electrode, A.W.S. classification 8018-C3. 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 28 Electrode has typical tensile strength of 87,000 P.S.I. and exhibits excellent low temperature impact properties.

RECOMMENDED APPLICATIONS

Eureka 28 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	Ni
.08	.90	.70	1.0

PHYSICAL AND OR MECHANICAL PROPERTIES

TENSILE STRENGTH 87,000 psi

YIELD STRENGTH 77,000 psi

ELONGATION 31%