

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 330 ELECTRODE

Dated: March 31, 1995

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INTRODUCTION

Eureka 330 Electrode is a smooth running rutile coated stick electrode with a AWS E330 chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka 330 Electrodes deposits exhibit good corrosion and oxidation resistance at extreme temperatures. The deposits have good high temperature strength and creep resistance qualities.

RECOMMENDED APPLICATIONS

Eureka 330 Electrodes are used for the welding of cast and wrought metals of similar chemical composition. It has good high temperature oxidation resistance, and high temperature creep strength up to 1800° F. It is used on boilers, baskets, furnace parts, and high temperature castings of similar chemistry.

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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 | 16.5 | 35.0 |

PHYSICAL AND OR MECHANICAL PROPERTIES

TENSILE STRENGTH 84,000 psi

YIELD STRENGTH 56,000 psi

ELONGATION 29%