

# Eureka Welding Alloys

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## TECHNICAL DATA FOR EUREKA 350 ELECTRODE

**Dated:** March 31, 1995

**Revised:** July 8, 2013

## INTRODUCTION

**Eureka 350 Electrode** is a smooth running rutile coated stick electrode that has a 410 Nickel Molybdenum chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

## METALLURGICAL CHARACTERISTICS

**Eureka 350 Electrodes** are a low carbon martensitic stainless steel alloy. The as welded hardness is 35 - 40 HRC and is readily machinable. **Eureka 350 Electrode** weld deposits have a high tensile strength and are quite corrosion resistant. The weld deposits are ideally suited for heavy build ups in moderate wear conditions. The weld deposits flow very freely, producing extremely dense, crack, and porosity free weld deposits.

## RECOMMENDED APPLICATIONS

**Eureka 350 Electrodes** are for the welding of 410 and 410NiMo castings and wrought metals. It is used in the repair, reclamation and joining of die casting dies, forging dies, arbors and shafts. It can be used as an underlay material in crack sensitive areas when a harder alloy is to be used as an overlay. Deposits polish to a high luster with a medium resistance to abrasion and are highly crack resistant due to its high tensile strength.

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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	Mo
.06	.50	.40	11.5	4.5	.50

## PHYSICAL AND OR MECHANICAL PROPERTIES

**TENSILE STRENGTH** 165,000 psi

**ELONGATION** 23%

## AS WELDED HARDNESS

**35- 40 HRC**