

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 350 SOLID MIG WIRE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 350 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 350 Solid MIG Wire is a low carbon martensitic stainless steel alloy. The as welded hardness is 35 - 40 HRC and is readily machinable. **Eureka 350** 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 Solid MIG Wire is 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	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

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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