

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 350 TIG RODS

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INTRODUCTION

Eureka 350 TIG Rods are drawn, straightened, cut to length, and then cleaned and packaged to obtain microscopically clean weld deposits. These rods are designed for the most critical applications where weld metal cleanliness is most important.

METALLURGICAL CHARACTERISTICS

Eureka 350 TIG Rod 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 TIG Rod 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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RECOMMENDED SHIELDING GASES

100% Argon

GAS FLOW RATE

20-40 CFH

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