

Eureka Welding Alloys

2000 E. Avis Drive

Madison Heights, MI 48071

Phone: 248-588-0001 Fax: 248-585-7711 Toll Free: 800-962-8560

E-mail: info@eurekaweldingalloys.com Website: www.eurekaweldingalloys.com

TECHNICAL DATA FOR EUREKA 5545 SOLID MIG WIRE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 5545 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 5545 Solid MIG Wires produces Copper-Nickel weld deposits which are soft, ductile, homogeneous and porous free. The weld deposits are fully machinable and have an excellent color match on cast iron. The weld deposits have low temperature fusion with the slightest degree of penetration. The weld deposits are free of cracking and porosity when applied to the lowest quality grades of cast iron.

RECOMMENDED APPLICATIONS

Eureka 5545 Solid MIG Wires is used for welding of Monel 400 and Monel K500. Eureka 5545 is used to join or repair grey, nodular and malleable cast irons. When welding on cast iron it produces machinable weld deposits that have excellent color match. **Eureka 5545** is outstanding for welding cracked, worn or defective castings and for correcting machining and design errors.

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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

GAS FLOW RATE

20-60 CFH

TYPICAL CHEMISTRY

C	Mn	Si	Cu	Ni	Ti
.01	2.0	1.0	65.0	Bal	2.0

PHYSICAL AND OR MECHANICAL PROPERTIES

TENSILE STRENGTH 66,000 psi

ELONGATION 40%