

Eureka Welding Alloys

2000 E. Avis Drive

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TECHNICAL DATA FOR EUREKA 5545 TIG RODS

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 5545 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 5545 TIG Rods produces Copper-Nickel weld deposits which are soft, ductile, homogeneous and porous free. The weld depositions 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 TIG Rods 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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RECOMMENDED SHIELDING GASES

100% Argon

GAS FLOW RATE

20-40 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%

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TEMPERING DATA

The tempering data is to be used as a guide. Your results may differ due to the many variables in the utilization of this product.

SINGLE TEMPER CURVE EUREKA 1215

