

Eureka Welding Alloys

2000 E. Avis Drive

Madison Heights, MI 48071

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

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TECHNICAL DATA FOR EUREKA 615 ELECTRODE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 615 Electrode is a smooth running basic coated stick electrode that is a low alloy filler metal. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka 615 Electrode is a carefully balanced Chromium, Molybdenum and Nickel alloy that has an as welded hardness of 13-23 HRC. This alloy displays high impact properties and moderate abrasion resistance.

RECOMMENDED APPLICATIONS

Eureka 615 Electrodes is an excellent choice for welding forging components such as rams, sow blocks, die holders, die shanks, hammers bases and columns. It is also utilized in steel mills and in maintenance shops for welding general machine parts such as steel gears, large arbors and shafts.

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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	Mo	Ni
.08	.70	.30	.70	.30	1.2

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

13-23 HRC

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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 615

