

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 FLUX CORED WIRE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 615 Flux Cored Wire is a low alloy filler metal. The wire has a smooth spray transfer arc with a thin slag system that is easily removable. The wire is formulated to develop high quality weld deposits that are porous and crack free. The wire is designed for multi-pass welding which greatly increases productivity.

METALLURGICAL CHARACTERISTICS

Eureka 615 Flux Cored Wire 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 Flux Cored Wire 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

TYPE	SIZE	AMPERAGE	VOLTS
Metal Cored Wire	.045" 1.2 mm	125 – 225	16 – 28
Metal Cored Wire	1/16" 1.6mm	180 – 400	25 – 33
Flux Cored Wire	1/16" 1.6mm	180 – 400	25 – 33
Flux Cored Wire	3/32" 2.4mm	350 – 600	27 – 35
Flux Cored Wire	1/8" 3.2mm	500 – 900	30 – 38

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

.045" 1.2 mm 20-50 CFH

1/16" 1.6mm 30-60 CFH

3/32" 2.4mm 80-120 CFH

1/8" 3.2mm 80-120 CFH

TYPICAL CHEMISTRY

C Mn Si Cr Mo Ni

.08 .70 .30 .70 .30 1.2

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PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

13-23 HRC

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

