

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 72 ELECTRODE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 72 Electrode is a smooth running basic coated stick electrode with a H-12 chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka 72 Electrode is a Chromium, Molybdenum, Tungsten, and Vanadium hot working alloy. It has excellent hot hardness, wear resistance and displays reasonable impact resistance. The as welded hardness is 50 - 55 HRC

RECOMMENDED APPLICATIONS

Eureka 72 Electrode is used for repairing or building of hot and cold trim and shearing dies, punches, extrusion dies and die casting dies. It is an excellent choice for press forging dies where high heat and abrasion are encountered. A typical application is the automobile connecting rod forging. High volume forgings that demand the ultimate in weld metal mechanical properties would be connecting rod, sleeve yoke, and hand tools. These applications are relatively shallow and usually high production.

Other forged products would include earth moving equipment and farm implements, hooks and lever brake bands and other shallow impressions, such as hand tools, pipe wrenches, and crankshafts.

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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	W	V
.35	.35	1.0	5.0	1.5	1.3	.30

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

50-55 HRC

TENSILE STRENGTH

185,000 psi

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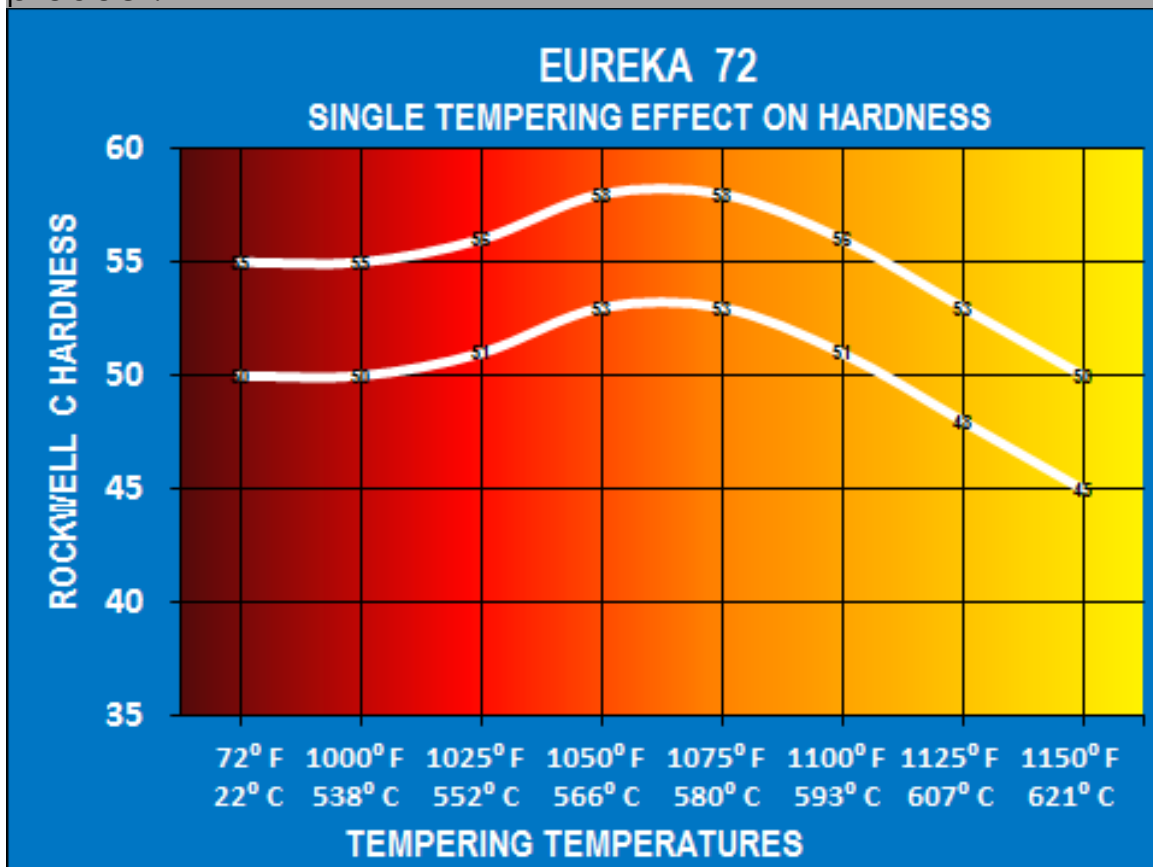
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TEMPERING DATA

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.



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