

# Eureka Welding Alloys

2000 E. Avis Drive

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## TECHNICAL DATA FOR EUREKA 72 SOLID MIG WIRE

**Dated:** March 31, 1995

**Revised:** July 8, 2013

## INTRODUCTION

**Eureka 72 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 72 Solid MIG Wire** is a H-12 hot working tool steel 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 Solid MIG Wire** 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	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

100% CO2 may produce lower quality arc conditions

## GAS FLOW RATE

20-60 CFH

## TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo	W	V
.35	.35	1.0	5.0	1.5	1.3	.30

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## PHYSICAL AND OR MECHANICAL PROPERTIES

### AS WELDED HARDNESS

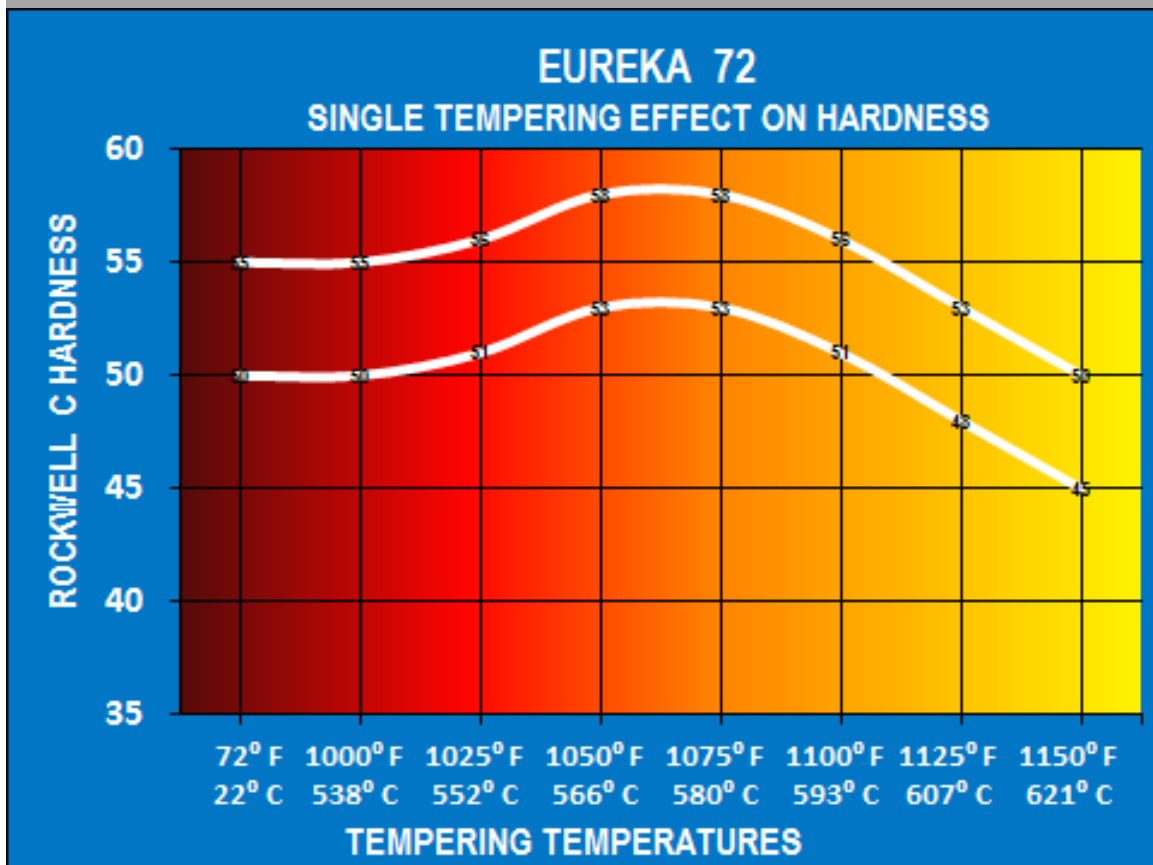
**50-55 HRC**

### TENSILE STRENGTH

**185,000 psi**

### 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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