

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 88 ELECTRODE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka 88 Electrode is a smooth running rutile coated stick electrode with an H-19 chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka 88 Electrodes has an as welded hardness of 55 - 60 HRC. The weld deposits are very resistant to wear at elevated temperatures, display good thermal fatigue resistance, and retains good hot hardness. This alloy is an A.I.S.I. type H-19 hot work tool steel containing high levels of Chromium, Cobalt, Tungsten and Vanadium.

RECOMMENDED APPLICATIONS

Eureka 88 Electrodes are used on hot punches and trim dies, hot extrusion dies, hot press forging dies and forging die inserts. It is used in areas where severe heat and abrasion will be encountered. Some forged dies would be hand tools, gears, discs and connecting rods. This alloy performs well in shallow impressions and is often use as an overlay or hard facing alloy.

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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	Co
.40	.35	.30	4.5	.45	4.3	2.0	4.3

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

55-60 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 88



