

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 99 Ni ELECTRODES

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INTRODUCTION

Eureka 99 Ni Electrode is a smooth running basic electrode for welding cast iron. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka 99 Ni Electrode is a Nickel electrode designed to produce high strength, porous free, non-cracking welds on grey cast iron, such as Malleable, Ductile Iron, Meehanite, and Ni-Resist. Weld deposits of **Eureka 99 Ni** are readily machinable, and may be used to join the above listed iron materials.

RECOMMENDED APPLICATIONS

Eureka 99 Ni Electrode can be used on just about every conceivable application in the maintenance repair welding of cast iron units such as gears, sprockets, motor housings, machine bases, cams, levers and draw dies.

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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