

# Eureka Welding Alloys

2000 E. Avis Drive

Madison Heights, MI 48071

Phone: 248-588-0001 Fax: 248-585-7711 Toll Free: 800-962-8560

E-mail: [info@eurekaweldingalloys.com](mailto:info@eurekaweldingalloys.com) Website: [www.eurekaweldingalloys.com](http://www.eurekaweldingalloys.com)

## TECHNICAL DATA FOR EUREKA BU SOLID MIG WIRE

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**Revised:** July 8, 2013

## INTRODUCTION

**Eureka "BU" 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 "BU" Solid MIG Wire** produce weld deposits of approximately 95,000 psi tensile strength and has 25% elongation.

## RECOMMENDED APPLICATIONS

**Eureka "BU"** is a triple deoxidized filler metal that yields dense porous free weld deposits. It is used for high strength joining and fabrication of low alloy and mild steels. It also can be utilized as an underlay prior to the deposition of a hard facing alloy.

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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	Mo
.08	1.9	.60	.50

## PHYSICAL AND OR MECHANICAL PROPERTIES

TENSILE STRENGTH 95,000 psi

YIELD STRENGTH 84,000 psi

ELONGATION 22%