

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA "C" TIG RODS

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INTRODUCTION

Eureka "C" TIG Rods are drawn, straightened, cut to length, and then cleaned and packaged to obtain microscopically clean weld deposits. These rods are designed for the most critical applications where weld metal cleanliness is most important.

METALLURGICAL CHARACTERISTICS

Eureka "C" TIG Rods has good resistance to pitting, stress-corrosion cracking, and oxidizing in atmospheres up to 1,900° F. It also provides superior corrosion resistance to many types of chlorides and salts. It is a hard surfacing and a heat resisting alloy that corresponds to AWS ERNiCrMo-4. This alloy resists extreme thermal shock and work hardens up to 40 HRC.

RECOMMENDED APPLICATIONS

Eureka "C" TIG Rods are used for welding C 276 to itself and to various grades of stainless steels. It is used for joining or repairing many nickel based alloys. It is also used to hard face tools and dies requiring a resistance to heat, abrasion, impact, erosion, corrosion or any combination of these conditions. They have been exceptionally successful when used for facing forging dies. Other applications are entry roll guides, tongs, twist roll guides, hot trim dies and dummy blocks. This alloy is untied as an underlay alloy for waspalloy or udimet (Eureka CWD) overlays in the open die forging industry.

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RECOMMENDED SHIELDING GASES

100% Argon

GAS FLOW RATE

20-40 CFH

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo	W	Ni
.01	.50	.50	15.5	16.0	3.7	Bal

PHYSICAL AND OR MECHANICAL PROPERTIES

TENSILE STRENGTH 110,000 psi

ELONGATION 30%

WORK HARDENS UP TO 40 HRC