

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA COLORMOLD SOLID MIG WIRE

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INTRODUCTION

Eureka Colormold 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 Colormold Solid MIG Wire weld deposits are a low alloy (chrome/moly) which is similar in chemistry to P-20, except that Carbon levels are intentionally held low to obtain hardness values in the low 25-35 HRC range as welded. At this hardness level, the deposits have the similar etching, graining, and color match characteristics as P-20 in the low 30 HRC range.

RECOMMENDED APPLICATIONS

Eureka Colormold is used to repair many types of P-20 tools and dies, whether they are die casting dies or plastic injection molds. It is often used for high strength joining of low alloy steels and Chrome Moly steels.

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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
.08	.55	.55	1.35	.50

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

25-35 HRC

TENSILE STRENGTH 90,000 psi

YIELD STRENGTH 75,000 psi

ELONGATION 23%

