

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA COLORMOLD TIG RODS

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INTRODUCTION

Eureka Colormold 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 Colormold TIG Rods 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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RECOMMENDED SHIELDING GASES

100% Argon

GAS FLOW RATE

20-40 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%