

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 Website: www.eurekaweldingalloys.com

TECHNICAL DATA FOR EUREKA P-20 ELECTRODE

Dated: March 31, 1995

Revised: July 8, 2013

INTRODUCTION

Eureka P-20 Electrode is a smooth running basic coated stick electrode with low alloy chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka P-20 TIG weld deposits are a medium carbon low alloy steel which contain chromium and molybdenum. The deposits are that of an AISI P-20 mold steel. The as welded hardness is 35-45 HRC. The hardness is highly dependent on preheat temperature, length of time welding, and cooling rate. The deposits have the similar etching, graining, and color match characteristics as P-20 when tempered to the low 30 HRC range.

RECOMMENDED APPLICATIONS

Eureka P-20 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.

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 Website: www.eurekaweldingalloys.com

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

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo
.35	.30	.50	1.70	.40

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

35-45 HRC