

Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA P-20 TIG RODS

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INTRODUCTION

Eureka P-20 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 P-20 TIG Rods 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.

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RECOMMENDED SHIELDING GASES

100% Argon

GAS FLOW RATE

20-40 CFH

TYPICAL CHEMISTRY

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

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

25-35 HRC