

Eureka Welding Alloys

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TYPICAL WELDING PROCEDURE

The following procedures should be utilized for the repair of

Welding Procedure Axial Cone

- A.** Under cut .300 (Machine)
 - B.** Remove all cracks 100% w/ carbon arc.
 - C.** Pre-heat to 900 degrees F. (Maintain until finish)
 - D.** Fill deep cracks, flush w/ Eureka # Tri-Cor 35
 - E.** Use the sub arc process to apply .150. Layer of Eureka #CHD (peen thoroughly). Clean with needle scaler and wire brush.
 - F.** Use GMAW process to apply .150 and clean up. Use 90/10 argon Co2
 - G.** Cover and cool to room temperature.
 - H.** Temper at 1050 degrees for 8 hours at temp.
 - I.** Slow cool in furnace, or cover.
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