Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA 1215 TIG RODS

Dated: March 31, 1995 **Revised:** July 8, 2013

INTRODUCTION

Eureka 1215 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

Eureka1215 TIG Rods are a AISI A-2 air hardening tool steel alloy. The as welded hardness of the deposits will typically be 55–60 HRC which can be tempered to lower hardness when necessary. This alloy has good wear resistance and moderate impact resistance.

RECOMMENDED APPLICATIONS

Eureka 1215 TIG Rods are recommended for welding AISI A-2 air hardening tool steels and other air hardening grades. Typical applications encountered are trim steels, piercing punches, flange, and forming dies as well as some draw form operations. This alloy is most widely used for general repair of the air hardening grades and AISI D-2 where a complete heat treat cycle will be used.

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RECOMMENDED SHIELDING GASES

100% Argon

GAS FLOW RATE

20-40 CFH

TYPICAL CHEMISTRY

C Mn Si Cr Mo V

1.0 .50 .25 5.0 1.2 .35

PHYSICAL AND OR MECHANICAL PROPERTIES AS WELDED HARDNESS

55-60 HRC

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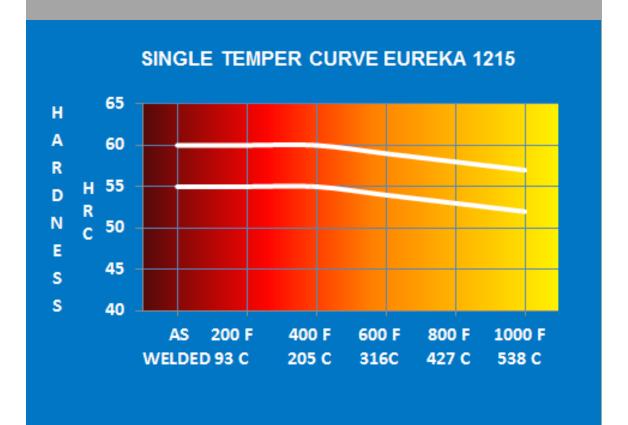
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TEMPERING DATA

The tempering data is to be used as a guide. Your results may differ due to the many variables in the utilization of this product.



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