## 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 625 FLUX CORED WIRE

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

### INTRODUCTION

**Eureka 625 Flux Cored Wire** is a low alloy filler metal. The wire has a smooth spray transfer arc with a thin slag system that is easily removable. The wire is formulated to develop high quality weld deposits that are porous and crack free. The wire is designed for multi-pass welding which greatly increases productivity.

#### **METALLURGICAL CHARACTERISTICS**

Eureka 625 Flux Cored Wire is a carefully balanced Chromium, Molybdenum and Nickel alloy that has an as welded hardness of 23-30 HRC. This alloy displays high impact properties and moderate abrasion resistance.

#### RECOMMENDED APPLICATIONS

**Eureka 625 Flux Cored Wire** is an excellent choice for welding forging components such as rams, sow blocks, die holders, die shanks, hammers bases and columns. It is also utilized in steel mills and in maintenance shops for welding general machine parts such as steel gears, large arbors, rolls and shafts.

### 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: <a href="mailto:info@eurekaweldingalloys.com">info@eurekaweldingalloys.com</a> Website: <a href="mailto:www.eurekaweldingalloys.com">www.eurekaweldingalloys.com</a>

#### **WELDING PARAMETERS**

TYPE	SIZE	AMPERAGE	VOLTS
Metal Cored Wire	.045" 1.2 mm	125 – 225	16 – 28
Metal Cored Wire	1/16" 1.6mm	180 – 400	25 – 33
Flux Cored Wire	1/16" 1.6mm	180 – 400	25 – 33
Flux Cored Wire	3/32" 2.4mm	350 – 600	27 – 35
Flux Cored Wire	1/8" 3.2mm	500 – 900	30 – 38

Use DC Current with a Stick Out of 1/4"-1 1/4" (6mm-32mm)

#### RECOMMENDED SHIELDING GASES

75% Argon, 25% Co2 90% Argon, 10% Co2 92% Argon, 8% Co2

100% CO2 may produce lower quality arc conditions

#### **GAS FLOW RATE**

.045" 1.2 mm 20-50 CFH 1/16" 1.6mm 30-60 CFH 3/32" 2.4mm 80-120 CFH 1/8" 3.2mm 80-120 CFH

### TYPICAL CHEMISTRY

C Mn Si Cr Mo Ni .08 1.4 .50 1.3 .60 2.2

# 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

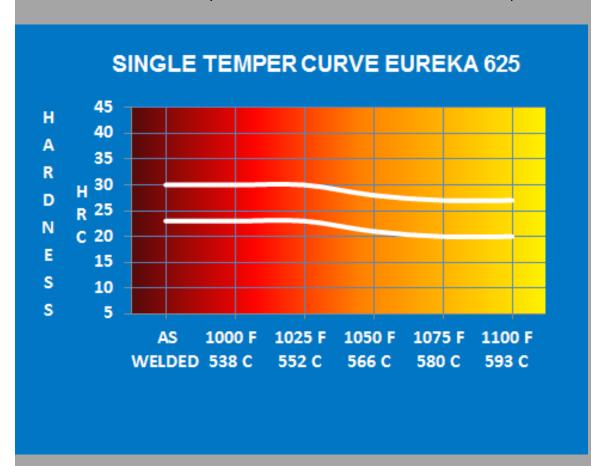
#### PHYSICAL AND OR MECHANICAL PROPERTIES

#### **AS WELDED HARDNESS**

23-30 HRC

#### **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.



Page 3 of 3 The data herein is to be used as a guide. Your results may differ due to the many variables in the utilization of this product.