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 74 SOLID MIG WIRE

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

INTRODUCTION

Eureka 74 Solid MIG Wires are drawn, cleaned, spooled and packaged to obtain smooth wire feeding with a stable spatter free arc. These wires are designed for the most critical applications where weld metal cleanliness is most important.

METALLURGICAL CHARACTERISTICS

Eureka 74 Solid MIG Wires is a AISI type S-7 shock resisting 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 works well in cutting or shearing environments at room temperature due to its unique ability of having high strength and being tough.

RECOMMENDED APPLICATIONS

Eureka 74 Solid MIG Wires are recommended for welding A.I.S.I. S-7 tool steel, however, because its weld deposits can be tempered to various hardness values, it can also be used to repair other shock-resisting grades plus many types of water-hardening tool steel. Eureka 74 work exceptionally well on metal stamping blank trim and pierce dies where edge chipping causes burr on parts. Eureka 74 is an ideal electrode for building cutting edges on composite cold and hot trim sections and punches.

Page 1 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.

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	VOLTS
.035" 1.0mm	100 – 225	14 – 28
.045" 1.2mm	125 – 250	16 – 28
1/16" 1.6mm	180 – 400	22 – 33

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

20-60 CFH

TYPICAL CHEMISTRY

C Mn Si Cr Mo V

.50 .50 .60 3.3 1.5 .25

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

55-60 HRC

Eureka Welding Alloys

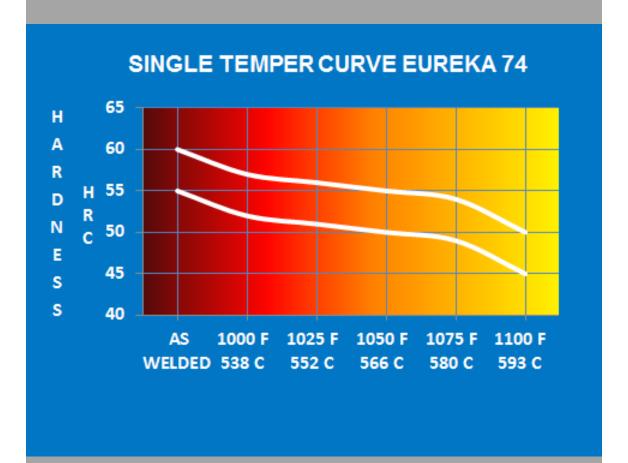
2000 E. Avis Drive Madison Heights, MI 48071

Phone: 248-588-0001 Fax: 248-585-7711 Toll Free: 800-962-8560

E-mail: info@eurekaweldingalloys.com Website: www.eurekaweldingalloys.com

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.