Eureka Welding Alloys

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TECHNICAL DATA FOR EUREKA COLORMOLD ELECTRODE

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INTRODUCTION

Eureka Colormold Electrode is a smooth running basic coated stick electrode with low alloy chemistry. The electrodes are designed for superior weldability having no spatter, a stable arc, good wet out, and easy slag removal.

METALLURGICAL CHARACTERISTICS

Eureka Colormold Electrodes weld deposits are a low alloy (chrome/moly) which is similar in chemistry to P-20, except that Carbon levels are intentionally held low to obtain hardness values in the low 25-35 HRC range as welded. At this hardness level, the deposits have the similar etching, graining, and color match characteristics as P-20 in the low 30 HRC range.

RECOMMENDED APPLICATIONS

Eureka Colormold Electrodes 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.

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.

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WELDING PARAMETERS

SIZE	AMPERAGE RANGE
3/32" 2.4mm	70 – 120
1/8" 3.2mm	100 – 140
5/32" 4.0mm	140 – 170
3/16" 4.8mm	170 – 225
1/4" 6.35mm	225 – 300
5/16" 7.94mm	300 – 375
3/8" 9.5mm	350 – 425

TYPICAL CHEMISTRY

C	Mn	Si	Cr	Mo
.08	.55	.55	1.35	.50

PHYSICAL AND OR MECHANICAL PROPERTIES

AS WELDED HARDNESS

25-35 HRC

TENSILE STRENGTH 90,000 psi

YIELD STRENGTH 75,000 psi

ELONGATION 23%

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