



TENALLOY 4130

LOW ALLOY STEEL (High Strength)



Low alloy Steel Electrode for welding AISI 4130 steel.

KEY FEATURES :

- Basic coated electrode
- Ni-Cr-Mo low alloy weld deposit
- Hardening and tempering is required to achieve desired properties
- Recommended preheat and interpass temperature is 200-315°C
- All position capability
- Radiographic quality weld

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Welding heat treatable alloy type AISI/SAE 4130 and 8630
- Suitable for steel casting with comparable hardening characteristics

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Ni
Range	0.12-0.25	1.0-1.80	0.25-0.75	1.0-1.80
	Cr	Mo	S	P
Range	0.5-1.0	0.20-0.50	0.020 max	0.025 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Range	PWHT: 871°C-Oil quenching Tempering at 621°C	800-1000	700-900	16 min
	PWHT: 871°C-Oil quenching Tempering at 510°C	1000-1200	900-1100	16 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
3.15 x 450	90-120	114	4	44
4.0 x 450	130-170	78	4	64
5.0 x 450	180-250	50	4	100