



Smoothcor 4130LN

Description

Smoothcor 4130LN is a basic flux cored electrode for use with Ar-25% CO₂ shielding gas. It is designed to weld 4130, and other steels of similar composition, such as 4140 and 8630. It provides a close match to steel properties following post weld heat treatment. The deposit contains less than 1% nickel making this electrode suitable for most oil field applications.

This electrode is intended for flat and horizontal fillet welding.

Typical Properties (Ar-25%CO₂ shielding)

Condition	Stress Relieve 1200F, 2 hrs	Austenitize 1625F, Water Quench, Temper 1100F, 1 hr.
Yield Strength (ksi)	98.6	115.8
Tensile Strength (ksi)	106.9	124.7
% Elongation	20.8	17.7
% Reduction of Area	55.1	57.8

Typical Deposit Chemistry:

Wt. %	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>	<u>Ni</u>	<u>Mo</u>	<u>Cr</u>
	0.20	1.18	0.70	0.008	0.013	0.80	0.21	0.64

Suggested Welding Parameters:

<u>Diameter</u>	<u>Optimum</u>			<u>Range</u>	
	<u>WFS</u>	<u>Amperage</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Voltage</u>
1/16"	320	300	29	250-450	27-33
.045"	380	250	28	120-320	22-31