

Select 4130LN

Description

Select 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 is also commonly used in casting repairs. 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 only.

Typical Deposit Chemistry (Ar-25%CO₂ shielding gas, all weld metal deposit):

C (wt%)	Mn (wt%)	Si (wt%)	P (wt%)	S (wt%)	Ni (wt%)	Cr (wt%)	Mo (wt%)
0.25	1.64	0.35	0.008	0.012	0.74	0.58	0.17

Suggested Welding Parameters:

<u>Diameter</u>	<u>WFS</u>	<u>Optimum</u>		<u>Range</u>	
		<u>Amperage</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Voltage</u>
3/32"	180	400	30	350-550	28-35
1/16"	320	300	29	250-450	27-33
.045"	380	250	28	120-320	22-31

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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field.