

## Select 4130LN

### Description

Select 4130LN is a basic flux cored electrode for use with Ar-25% CO<sub>2</sub> 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 only.

### Typical Properties (Ar-25%CO<sub>2</sub> shielding)

	<u>Condition Stress Relieve 1200F, 2 hrs</u>	<u>Austenitize 1625F, Water Quench, Temper 1100F, 1 hr.</u>
Yield Strength (psi)	98,600	115,800
Tensile Strength (psi)	106,900	124,700
% 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>
	.20	1.18	.70	.008	.013	.80	.21	.64

### 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>
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.