Inweld 4130

Chemical Composition of AISI/SAE 4130

Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Other	Al
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Values determined by the manufacturer.

Description and Applications

4130 is a Chome-Moly low alloy wire that produces a dense, heat-treatable deposit. This alloy is used to weld AISI/SAE 4130 and 8630 and other heat treatable alloys or base metals that require flame hardening. Preheat and inter-pass are recommended and can also be followed by post-heating.

Procedure

GMAW, GTAW

Typical Weld Metal Properties

	AWS Spec (psi)
Tensile Strength:	190,000
Yield Strength:	168,000
Elongation:	

Recommended Parameters

Wire Diameter	Voltage	Amperage
0.023”	14-19	30-85
0.030”	15-20	40-130
0.035”	16-25	60-235
0.045”	18-23	90-290