



WELDCOTE 4130

Description-Weldcote 4130 is a high strength, low alloy welding wire used for joining high strength steel of similar chemical composition and for overlay applications where moderate hardness is required. This wire may be used for the GMAW, GTAW, and SAW welding processes. A preheat and interpass temperature of 400°F is required.

Approvals- N/A

Chemical Composition-

Carbon	.30%	Molybdenum	.20%
Manganeses	.52%	Sulfur	.01%
Silicon	.28%	Phosphorus	.01%
Chromium	.95%	Aluminum	.005%
Nickel	.10%	Iron	Balance
Copper	.20%		

Mechanical Properties*

Elongation-4d	11%
Tensile Strength	145.0 Ksi
Yield Strength	130.0 Ksi

*The mechanical properties stated above were obtained by heating the weld metal to 1550°F, oil quenching and tempering at 1050°F.

Available sizes

Diameters- 1/16, 3/32 and 1/8"

Packaged in 10 pound cardboard tubes, 4 tubes in a 40 pound master.

WELDING PARAMETERS

Process	Electrical	Voltage	Amperage	Shielding Gas	Gas Flow, CFH	Welding Speed
GMAW <i>Spray Transfer</i>	DCEP	28 - 32	.035" (0.90mm) 165-200	98 Ar - 20 ₂	30 - 50	30-50 IPM
		30 - 34	.045" (1.14mm) 180-220			
			.062" (1.60mm) 230-260			
GMAW <i>Short Circuit</i>	DCEP	22 -25	.035" (0.90mm) 100 - 140	75 Ar - 25CO ₂		
		23 - 26	.045" (1.14mm) 120 -150			
GMAW <i>Globular</i>				100% CO ₂		
GTAW	DCEN	20	.093" (3.20mm) 125-175	100% Ar	30 - 40	
			.125" (3.20mm) 175-250			
SAW	DCEP	28	3/32" (2.50mm) 400	N/A	N/A	110 IPM
			1/8" (3.14mm) 450			80 IMP
			5/32" (4.00mm) 500			65 IPM