

COR™ALLOY 4130 FC

DESCRIPTION

COR™ALLOY 4130 FC is a flux-cored, AISI chrome-moly steel, and is readily available in MIG, TIG, and sub-arc versions.

APPLICATIONS

4130 FC is typically used to build up all types of dies, forgings, castings, and other machine parts made from medium carbon, low alloy steels. 4130 FC finds specific usage in joining 4130 or 4140 steels that will be fully heat-treated, or flame hardened.

PROCEDURE

A minimum preheat/interpass temperature of 400-500°F is recommended for AISI 4130, and 550-650°F for AISI 4140. Allow the welded part to cool as slow as possible. Heat treat according to AISI 4130 to desired hardness.

WELDING PARAMETERS

Size	Volts	Amps	Shielding Gas/Flux
MC-G .045"	18-30	150-250	CO ₂ or Ar-CO ₂ mixtures
FC-G 1/16"	20-30	200-300	CO ₂ or Ar-CO ₂ mixtures
FC-G 3/32"	26-29	250-350	CO ₂ or Ar-CO ₂ mixtures
FC-S 1/16"	25-30	200-250	Lincoln 880
FC-S 3/32"	28-32	350-450	Lincoln 880

MECHANICAL PROPERTIES

Hardness: 33-38 as welded
 Flame hardenable to 52 Rc

CLASSIFICATION

AISI 4130