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COR™ALLOY 4340 FC

DESCRIPTION

COR™ALLOY 4340 FC is a flux-cored, AISI nickel-chrome-moly steel, and is readily available in MIG, TIG, and sub-arc versions. The mechanical properties of this alloy depend on preheat/interpass temperature, cooling rate, and subsequent heat treatment.

APPLICATIONS

4340 FC is typically used where a medium hard, impact resistant weld is required. Typical uses include die-cast dies, crankshafts, gears, axles, forgings, castings, and buildup under harder weld deposits.

PROCEDURE

A minimum preheat/interpass temperature of 600-800°F is recommended for AISI 4340. Allow the welded part to cool as slow as possible. Post heat treat to desired hardness. Refer to the AISI 4340 procedure for a full heat treatment.

WELDING PARAMETERS

	Size	Volts	Amps	Shielding Gas/Flux
MC-G	.045”	18-30	150-250	CO_2 or Ar-CO_2 mixtures
MC-G	1/16”	20-22	200-250	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”	25-27	150-250	Lincoln 880
FC-S	3/32”	29-31	300-400	Lincoln 880
FC-S	1/8”	29-31	350-450	Lincoln 880

MECHANICAL PROPERTIES

Hardness: 35-47 as welded
Flame hardenable to 58 Rc

CLASSIFICATION

AISI 4340