



# TENALLOY 4130

LOW ALLOY STEEL (High Temperature)

### KEY FEATURES:

- Basic coated electrode
- Ni-Cr-Mo low alloy weld deposit
- Hardening and tempering is required to achieve desired properties
- Recommended preheat and interpass temperature is 200-315°C
- All position capability
- Radiographic quality weld.

### TYPICAL APPLICATIONS:

- Welding heat treatable alloy type AISI/SAE 4130 and 8630
- Suitable for steel casting with comparable hardening characteristics



### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.16	1.2	0.4	0.55	1.2	0.4

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Specification	PWHT: 871°C-Oil quenching Tempering at 621°C	800-1000	700-900	16 min
	PWHT: 871°C-Oil quenching Tempering at 510°C	1000-1200	900-1100	16 min

### PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 3.15 x 450 4.0 x 450 5.0 x 450	<b>Amperage, A</b> 90-120 130-170 180-250	 <b>DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down  
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Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing