

### Typical Applications:

- Metal Cored cut length wire designed for joining and repair of AISI 4340 without a quench and temper, only stress relief.
- High strength overmatch on steels such as Weldox 960
- Alloy Forging and Casting Repair

### Product Advantages:

- Flat, Horizontal Position Only
- High yield and tensile strength
- Flat bead
- Excellent Toughness
- 100% Argon shielding gas

Typical Mechanical Properties					
	UTS (ksi)	Yield (ksi)	%El	CVN(ft/lbs) -20F	Hardness (HV10)
SR 3hr at 1025°F	165	153	16	48	403

Typical Deposit Composition						
%C	%Mn	%Si	%Ni	%Mo	%Cr	%Cu
0.05 – 0.2	1 – 2	0.5 max	3 – 4	0.5 – 1.0	0.5 – 1.0	0.75 max

**Available Diameters:** 0.045", 3/32" (Additional sizes may be available upon request)

Typical Welding Parameters			
Diameter	Amperage Range	Voltage	Current
0.045"	280 – 300	13 - 14	DCEN
3/32"	170 – 200	15 – 15	DCEN

**Packaging:** The product is available on 25lb. spools or 10lb. cut length packages, vacuum packed and placed in a specially designed carton for long term storage.

**Moisture Control:** Devasco electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40°F to 120°F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 300-325°F in a warming oven for a minimum of 2 hours prior to use.

**NOTICE:** Data provided is based on typical results. **Actual results are tested per customer spec.** Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. [www.devasco.com](http://www.devasco.com) for additional information.

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