

Typical Applications:

- Metal Cored cut length wire designed for joining and repair of AISI 4130
- Alloy Forging and Casting Repair
- Excellent alternative to solid wire

Product Advantages:

- Low residual elements resulting in a very “clean” weld deposit
- Excellent Toughness
- Meets NACE requirements

Typical Mechanical Properties

	UTS (ksi)	Yield (ksi)	%El	CVN(ft/lbs) -50°F	Hardness (HV10)
As Welded	98	83	20	24	229 max
SR 8hr at 1175°F	91	77	19	35	109 max

Typical Deposit Composition

%C	%Mn	%Si	%Ni	%Mo
0.15 max	1 – 2	0.5 max	< 1.0	0.2 – 1.0

Available Diameters: 0.045” (Additional sizes may be available upon request)

Typical Welding Parameters

Diameter	Amperage	Voltage	Shielding Gas	Current
0.045”	190 – 210	27 – 28	95% Ar – 5% CO ₂	DCEP

Packaging: The product is available on 25lb. spools, 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 for additional information.
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