



**WA. ALLOY CO.**

WASHINGTON ALLOY'S Quality  
Management System is  
Certified to *ISO 9001:2008*  
Cert # 05-R0925

# 4140 Chrome-Moly Metal-Cored Wire



**American Welding Society**

Sustaining Company Member



## ALLOY DESCRIPTION AND APPLICATION:

4140MC is a metal cored wire designed for welding and build up on mild & low alloy steels having a smooth stable arc transfer, spatter free, excellent bead contour, with a high deposition rate and nearly free of slag weld bead. This wire is formulated to weld flat and horizontal which has deoxidizers that helps where mill scale may be present. This metal cored wire is typical used on dies, forgings, castings and other base metals where heat treating is required. Preheat and interpass of 500-650° F is found on AISI 4140 grades of base metal followed by slow cool and post weld heat treating to required hardness.

## TYPICAL METAL CORED WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	Gas <sup>(1)</sup> (cfh)
0.035	300-650	160-315	22-34	3/8-3/4"	35-40
0.045	200-550	150-325	20-31	1/2-1"	35-45
0.052	200-575	200-440	23-33	1/2-1"	40-50
1/16"	150-470	210-480	26-35	1/2-1.25"	40-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. <sup>(1)</sup>100 % CO<sub>2</sub> or 75% Ar/25% CO<sub>2</sub>

Hardness as welded 31-40 may be hardenable to 58

**AVAILABLE SIZES:** TU 4140MC= Spools of .045

Other sizes may be available – please inquire

**SPECIFICATIONS:** INTERNAL



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