Dual Shield II 4130 SR

Dual Shield II 4130 SR is an all position flux cored wire for welding low alloy, high strength steels such as 4130. Ideal for offshore oil and gas topsides and platforms requiring high corrosion resistance with stress relieved high strength and low temperature impact toughness properties. Excellent welder appeal and mechanical properties after PWHT. Meets ANSI/NACE MR0175/ISO 15156-1. Typical Diffusible Hydrogen: <4 ml/100g of deposited metal.

Specifications	
Classifications	AWS A5.29/A5.29M, ASME SFA 5.29 : E101T1-GM AWS A5.36/A5.36M : E101T1-M21AP5-G-H4

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
Stress Relieved 2 hour(s) 620 °C	648 MPa	731 MPa	26 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
Stress Relieved	-46 °C	43 J
Stress Relieved	-46 °C	69 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**S**	**P**	**Ni**	**Cr**	**Mo**
0.05	2.0	0.3	0.006	0.011	0.90	0.03	0.43

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**TTW Dist.**
1.2 mm	150-170 A	23-24 V	4,32 m/min	19 mm
1.2 mm	180-220 A	24-26 V	7,19 m/min	16 mm
1.2 mm	230-280 A	26-28 V	10,16 m/min	16 mm

Recommended Welding Parameters				
Current	**Wire Diameter**	**TTW Dist.**	**Voltage**	**Wire Feed Speed**
150-170 A	1.2 mm	19 mm	23-24 V	432 cm/min
180-220 A	1.2 mm	16 mm	24-26 V	719 cm/min
230-280 A	1.2 mm	16 mm	26-28 V	1016 cm/min