




<p align="center">DESIGNATION AND DESCRIPTION</p>	<p align="center">Weldtool® Technologies, Inc 4140</p> <p align="center">GTAW,GMAW, SAW, SMAW</p>		<p align="center">DATA SHEET</p> <p align="center">Revision B</p>																																			
<p align="center">CROSS-REFERENCE CONFORMANCE SPECIFICATIONS</p>	<p>AMS 6452 (WHEN SPEC.) MIL-R-5632 Type II (WHEN SPEC.) AISI 4140 0.95Cr 0.2Mo (0.38-0.43C)</p>																																					
<p align="center">METALLURGICAL BACKGROUND INFORMATION</p>	<p>Weldtool 4140 is a specialist alloy solid wire cored and steel electrodes.</p> <p>These manufacturing processes ensure consistent metallurgical integrity of the alloy with regard to control of trace elements and physical purity of the welding wire surface.</p> <p>Weldtool 4140 is a high strength Cr,Mo C steel filler metal used for fabricating critical joints of similar composition base metal.</p>																																					
<p align="center">MATERIALS TO BE WELDED AND APPLICATIONS</p>	<p>UNS G41400 - AISI 4140. Tubular frames for engines. Weapons and defense equipment. Tooling. Use ultra clean weldment preparation. Refer to PH & PWHT chart.</p>																																					
<p align="center">WIRE CHEMISTRY WT%</p>	<table border="0"> <tr> <td>Carbon</td> <td>0.38</td> <td>0.43</td> <td>Nickel</td> <td>-</td> <td>0.25</td> </tr> <tr> <td>Manganese</td> <td>0.75</td> <td>1.00</td> <td>Molybdenum</td> <td>0.15</td> <td>0.25</td> </tr> <tr> <td>Silicon</td> <td>0.15</td> <td>0.35</td> <td>Copper</td> <td>-</td> <td>0.35</td> </tr> <tr> <td>Sulfur</td> <td>-</td> <td>0.008</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Phosphorus</td> <td>-</td> <td>0.008</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Chromium</td> <td>0.80</td> <td>1.10</td> <td></td> <td></td> <td></td> </tr> </table>		Carbon	0.38	0.43	Nickel	-	0.25	Manganese	0.75	1.00	Molybdenum	0.15	0.25	Silicon	0.15	0.35	Copper	-	0.35	Sulfur	-	0.008				Phosphorus	-	0.008				Chromium	0.80	1.10			
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<p align="center">WELD PROPERTIES</p>	<p>Melting Point: 2740°F CVN: 58.3ft lbs at 0°F, 100% shear. (Minimum specification requirement: 28 CVN).</p>																																					
<p align="center">SIZES AND FORMS AVAILABLE</p>	<p align="center">STRAIGHT LENGTHS</p> <p>5 lb. (2.2kg) packs 36" (914mm) lengths Flag tagged for traceability. (Double tagging and other lengths on request) Wide range of diameters.</p>	<p align="center">SPOOLED WIRE</p> <p>Precision layer wound, with controlled cast and helix 12" (300mm) diameter spools standard 8" (200mm), 4" (100mm) and proprietary pool sizes on request. Wide range of diameters and spool weights.</p>																																				
	<p>2440 N. Glassell Street, Unit X Orange, CA 92865 Toll Free: 866-936-3354 Warehouse: 714-646-7527 FAX: 714-459-7016</p> <p align="right">Info@weldtool.com www.weldtool.com</p>																																					