ALLOYS QUALITIUM™
ULTIMATE GENERATION

Alloys Qualitium Ecologic

ALLOY C-4300 M

MAINTENANCE ALLOYS QUALITIUM

DESCRIPTION: ALLOY C-4300 M is used for welding ductile, malleable, and gray cast iron components to themselves or to low-alloy or carbon steels. It can be machined by using carbide tipped tools. A preheat and interpass temperature of 350ºF (175ºC) minimum is recommended during welding to prevent the weld and heat affected zones from cracking. ALLOY C-4300 M can be used in all positions.

TYPICAL CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Others
.05		55.0		.25	.15		.03 max	44.0		1.0 max

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	89,500 psi (620 MPa)
Yield Strength	62,000 psi (430 MPa)
Elongation	35%

TYPICAL WELDING PARAMETERS:

	Diameter	Voltage	Amperage	Shielding Gas
MIG	.035” (.9mm) .045” (1.14mm) .062” (1.6mm)	26-29 28-32 29-33	160 /210 180/250 200/280	75% Ar/25 He
TIG	.035” (.9mm) .045” (1.14mm) 1/16” (1.6mm) 3/32” (2.4mm) 1/8” (3.2mm) 5/32” (4.0mm)	12-15 13-16 14-18 15-20 15-20 15-20	60-90 80-110 90-130 120-175 150-220 150-220	100% Ar
SAW	3/32” (2.4mm) 1/8” (3.2mm) 5/32” (4.0mm)	28-30 29-32 30-33	275-350 350-450 400-550	Suitable Flux

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus, the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.