



340T TIG Wire



340M MIG Wire



Overview

340 Electrode (SMAW), 340T TIG Wire (GTAW) and 340M MIG Wire (GMAW)

The Chrome-Moly Conqueror

The ultimate thermoreactive welding alloy for specific use with all types of chromium-molybdenum steel. This uniquely alloyed system will respond to almost all chrome-moly and martensitic stainless steel heat treatments and retain its superior mechanical properties without cracking. The mechanical properties of the as-deposited weld metal are similar to those of most heat-treated chrome-moly steels.



340 Electrode

Features/Benefits

- Weld deposits are tough, low carbon martensitic structure, smooth, dense, free of porosity and cracks
- Excellent for joining and overlaying chrome-moly steels and martensitic stainless steels
- Resistant to moderate corrosion and heat scaling, up to 1,200°F (650°C)
- Low coefficient of friction makes 340 ideal for buildup and surfacing of chrome-moly steels
- Ideally suited for high-temperature applications, up to 800°F (425°C)
- Excellent machinability on all base metals

Applications

- Tubular frames
- Shaft buildup
- Turbine buckets
- Roll bars
- Fixtures
- Blades
- Fractured tools
- Bearing surfaces
- Forging dies

Method of Application

Electrode: DC reverse polarity; TIG: DC straight polarity

Identification

Arc: Printed electrode; TIG: Embossed/tagged; MIG: Labeled spool

Directions for Use

Select the arc welding process to be used for the job. Clean the base metal by removing all foreign materials, fatigued metal and any sharp radii. Most chrome-moly steels and martensitic stainless steels need to be preheated from 400°F to 600°F (205°C to 315°C), depending on the AISI type (4130, 4140 or 410, 416 respectively). If postweld heat treatment is required, reference the AISI base metal type. When TIG welding (GTAW), use direct current (DC) straight polarity (DCEN or DCSP). 100% Ar shielding gas is recommended at a flow rate of 15 to 20 cfh (.42 to .55 m³/hour).

Technical Specifications

Tensile Strength: 140,000 PSI (814 MPa)
Hardness: Rc 40

Elongation: 25%
Gas: TIG – 100% Ar; MIG – 98% Ar, 2% O₂