

HARDFACE 400-E

CLASSIFICATION

DIN 8555 : E1-UM-400

EN 14700 : E Fe1

DESCRIPTION AND APPLICATIONS

- Rutile coated electrode
- Excellent weldability out of positions
- Crack-resistant deposit
- Repair, rebuilding and buffering of castings
- Applications : shafts, rollers, wheels, etc, in the mining and civil engineering industries
- Complements Welding Alloys cored wire HARDFACE P, Robodur K 350-G

TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Fe
0.30	0.50	1.00	1.50	Balance

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – as welded

~ 400 HB

OPERATING CONDITIONS

Electrode ØxL [mm]	2.5x350	3.2x450	4.0x450
Current [A]	90	115	160

Redrying, if necessary, 1h/150°C. Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. have to be preheated to 250–400°C, depending on their composition and thickness. Slow cooling in still air after surfacing.

= - ~ 45 V

WELDING POSITIONS

1G/PA, 2F/PB, 2G/PC, 3G/PF, 4G/PE

PACKAGING

Electrode ØxL [mm]	2.5x350	3.2x450	4.0x450
Weight/box [kg]	5	6.5	6.5
Piece/box	~ 251	~ 167	~ 102