

ROBODUR K 400-G

CLASSIFICATION

EN 14700 T Fe1

DIN 8555: MSG 1-GF-400

DESCRIPTION

- Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing
- Unique welder appeal
- Deposition rate increased by up to 20% when compared to solid wire
- Martensitic weld metal contains finely dispersed hard carbides ensuring an optimal balance between abrasion, friction and impact resistance
- Wire does not pick up moisture, the wire feeding properties are excellent
- Designed for welding in horizontal, horizontal-vertical and vertical-up positions
- Abrasion resistance is maintained at service temperatures up to 350°C

APPLICATIONS

ROBODUR K 400-G is used for hardsurfacing components that must combine resistance both to abrasion and to moderate impact

Examples

Bucket teeth, bucket lips, bulldozer blades, crusher jaws, scraper blades, chutes, pump housings, conveyor screws, slide plates, gear teeth, crusher hammers, drilling bits, ploughshares, dies, impact drills etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Ti	Fe
0.15	1.65	0.80	3.20	0.40	+	Bal.

Microstructure: martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-Layer deposit:

As welded 40-44 HRc

CONDITIONS OF USE

Current type	Shielding gas
DC (+)	M12 / M13 / M21

EN ISO 14175

M12 / M13 / M21

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	110 - 300	16 - 32	12 - 25	10 - 20
1.6	130 - 350	16 - 32	12 - 25	10 - 20

Recovery: > 98 %

WELDING POSITIONS

ROBODUR K400-G is suitable for downhand as well as for positional welding by adapting transfer mode and welding parameters as for solid wires

STANDARD DIAMETERS (mm)

1.2, 1.6

Other diameters: please consult us

PACKAGING

Diameter	1.2 mm	1.6 mm
Standard packaging [EN ISO 544]	Spool : BS 300	Spool : BS 300
Weight	15 kg	15 kg