

DURWELD 400

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Fe3 DIN 8555 : E 1-UM-400 P	UDT	Hardfacing and repairing

- Electrode with the addition of Cr and Mn
- Excellent slag release, low spatter.
- The joint is covered with an uniform, very fine scale.
- For hardfacing elements where high impact resistance and medium abrasion are required.
- Recommended for surfacing parts exposed to wear.
- For the regeneration of railway tracks (along with buffer made with electrode 307).
- Good weldability in most positions.
- Deposit weld can be machined using appropriate turning or milling tools.
- In the case of material with a high carbon content and components responsible for increased hardenability, a buffer layer of material 307 or another of a similar composition should be used.

Application

Gears, chain links, rails, guides, rotors, etc. Regeneration and repair of rails.

Base material



Steel

Cast steels

Typical chemical composition %

C	Mn	Cr
0,22	1,00	1,50

Typical mechanical properties

Hardness	350 - 450 HB / The hardness of the overlay depends on the relevant welding conditions, the number of layers and the chemical composition of the base material. /
Coating type	basic
Welding current	
Welding positions	
Redrying	400°C / 1 h lub 300°C / 2 h

Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]	Pcs/1 kg
3,2	350 /	100-135	4,5	13,5	27
4,0	450 /	130-170	5,5	16,5	14
5,0	450 /	180-220	5,5	16,5	9

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