

<b>Technical data sheet</b>  <small>010623GB</small>	<b>Cored welding wire</b> <b>ROBODUR K 400-G</b>	
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### CLASSIFICATION

EN 14700: T Fe1

### DESCRIPTION

- Seamless high fill copper coated tubular wire for semi-automatic gas shielded hardfacing
- Machinable low alloy bainitic deposit
- Unique welder appeal
- Deposition rate increased by up to 20% when compared to solid wire
- Wire does not pick up moisture, the wire feeding properties are excellent
- Designed for welding in horizontal, horizontal-vertical and vertical-up positions

### APPLICATIONS

ROBODUR K 400-G is used for surfacing and rebuilding parts subjected to abrasion, high compressive stresses and impacts.

#### Examples

Rollers, idlers, chains and drive sprockets, excavator pads, steel shafts, gear teeth, crane wheels, bearing tracks, steel mill rolls, mine car wheels, dredge pins, dredge links, mixer parts, rail car couplings, steel mill roll couplings, cold forging dies and any components subject to metal-metal wear.

### TYPICAL ALL-WELD METAL ANALYSIS

C	Si	Mn	Cr	Mo
0.15	0.8	1.8	3	0.4

Microstructure: bainite

### TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness as welded, 3-layer deposit on mild steel: 40 HRC

### CONDITIONS OF USE

Current type	Shielding gas
DC-, DC+ or pulsed	M12: Ar + 0.5 – 5 % CO <sub>2</sub>
	M13: Ar + 0.5 - 3% O <sub>2</sub>
	M20: Ar + 5 – 15 % CO <sub>2</sub>
	M21: Ar + 15 – 25 % CO <sub>2</sub>

### OPERATING CONDITIONS

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

Direct polarity (DC-) reduces dilution and favours high hardness. It can be useful in special circumstances such as hardfacing on edges.

Recovery: 98%

### WELDING POSITIONS

ROBODUR K 400-G is suitable for both downhand and positional welding by adapting transfer mode and welding parameters as for solid wires.

### PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.