


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA HARDFACE 400-E	 Welding Alloys
---	--	---

CLASSIFICATION

EN 14700: E Fe1

DESCRIPTION

- Rutile coated electrode
- Low alloy martensitic deposit, resistant to impact and compressive stresses combined with moderate abrasion
- Multiple layers may be deposited, with preheat
- The weld deposit is machinable using carbide tools, and free from defects and cracks
- Weldability is excellent even using generators with low striking voltages
- Complements Welding Alloys cored wires HARDFACE P and ROBODUR K 450-G

APPLICATIONS

Hardfacing and multi-layer build-up work.

Examples

Tractor rollers, crane wheels, mine car wheels, cable drums and sheaves, shearing blades, caterpillar tracks, steel mill table rolls and other steel mill applications. Repairs to and rebuilding of forge tooling.

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	Cr	Fe
0.3	0.5	1.0	1.5	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness as welded: 400 HB / 39 – 42 HRc

OPERATING CONDITIONS

Electrode Ø x L [mm]	2.5 x 350	3.2 x 450	4.0 x 450
Current [A]	90	115	160
= -	~ 45V		

Preheating is not required on mild and medium carbon steels. Low alloyed, high carbon tool steels etc. need to be preheated to 200 - 400°C, depending on their composition and thickness. Cool slowly in still air after surfacing.

WELDING POSITIONS

EN ISO 6947: PA, PC, PF, PE
 ASME IX: 1G, 2G, 3G, 4G

PACKAGING

Electrode Ø x L [mm]	2.5 x 350	3.2 x 450	4.0 x 450
Weight/box [kg]	5	6.5	6.5

Other packaging and other sizes: please consult us