

CORODUR[®] 400

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Z Fe2 MF 1-40-P

GENERAL CHARACTERISTICS:

CORODUR 400 is a tubular wire that produces a low alloyed deposit for hardfacing of approximately 400 HB. Deposits are machinable. This electrode can be used for multi-layer welding. Applications are, e.g. wheel rims, chain links, bucket chains. For base materials with higher carbon content, a buffer layer or preheating must be anticipated.

APPLICATION:

Cable rolls, crane wheels, rails, guiding rolls, chain links, etc.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Mo	Ti
0,2	0,6	2,0	3,0	0,3	+

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 38 - 42 HRc

PARAMETER:

Diameter	Voltage	Amps
1,2	18 - 24	140 - 220
1,6	20 - 22	160 - 260
2,0	22 - 26	240 - 280
2,4	24 - 27	280 - 340
2,8	25 - 28	320 - 400

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg | Coil "BS 450" = 25 kg | Drums = 300 kg

OA = gasless, G = gas shielded, SA = Submerged Arc