

DUR E 400 KB

CATEGORY SMAW Stick Electrodes

TYPE Basic coated electrode for rebuilding machine parts and buffer layers.

APPLICATIONS Hardfacing, rebuilding, overlays, machine parts, wheels, buffer layers, etc

PROPERTIES Outstanding alloy against high impact combined with abrasion including metal to metal friction. The weld deposit of Dur E 400Kb is an exceptional easy to apply alloy without any risk for cracks and can also be applied on austenitic manganese steels. The weld deposit is machinable with tungsten tool tips. Very good weld deposit appearance and outstanding welding properties on both AC and DC+. Preheating is not required.

CLASSIFICATION

AWS	A 5.13: E Fe1
EN ISO	14700: E Fe1
DIN	8555: E1-UM-400 P

SUITABLE FOR Rebuilding worn machine parts, Stone crushers, Hammers, Gears, Cams etc.

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Cr	Fe
<0.15	<1.0	2.5-3.5	rem

MECHANICAL PROPERTIES

Heat Treatment	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Hardness HB		
				1st layer	2nd layer	3th layer
AW				350	375	400

AW: as welded, >375 HB without PWHT at RT

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters			Packing	
	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
3.2	350	100-140	2.8	16.8	
4.0	450	140-180	3,2	19,2	
5.0	450	180-220	3,2	19,2	

REDRYING TEMPERATURE 300-320°C/2hr