




HARDFACE 400-E

Manual Arc Electrode

Page 1 of 2

CLASSIFICATION	AS 2576, 1440-A4 WTIA(TN4), 1440-A4 EN 14700, E Fe 1										
DESCRIPTION	HARDFACE 400-E is a rutile all positional electrode with a smooth stable arc that produces a tough low carbon martensite deposit that is crack free and machinable with carbide cutting tools.										
APPLICATIONS	HARDFACE 400-E is used for hard facing and rebuilding steel components subject to metal to metal wear, moderate abrasion, compressive loading and plastic deformation. Typical items include tractor rollers, tractor idlers, crane wheels, cable drums, cable sheaves, steel mill table rolls, shovel track pads, stacker wheels and slideways.										
ALL WELD METAL PROPERTIES (TYPICAL)	Chemical (Wt%) : <table border="1"><thead><tr><th>C</th><th>Mn</th><th>Si</th><th>Cr</th><th>Fe</th></tr></thead><tbody><tr><td>0.30</td><td>1.0</td><td>0.50</td><td>1.5</td><td>Bal:</td></tr></tbody></table> Hardness 39-42 HRC (three layers , as welded) Hardness 400 HV (three layers, as welded)	C	Mn	Si	Cr	Fe	0.30	1.0	0.50	1.5	Bal:
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<p>WELDING PARAMETERS</p>	<p>HARDFACE 400-E</p>  <table border="1" data-bbox="470 451 885 619"> <thead> <tr> <th>Size (mm)</th> <th>Polarity</th> <th>Amperage (Amps)</th> </tr> </thead> <tbody> <tr> <td>3.2 x 450</td> <td>DC+</td> <td>120-140</td> </tr> <tr> <td>4.0 x 450</td> <td>DC+</td> <td>140 -160</td> </tr> </tbody> </table>	Size (mm)	Polarity	Amperage (Amps)	3.2 x 450	DC+	120-140	4.0 x 450	DC+	140 -160			
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<p>PACKAGING</p>	<table border="1" data-bbox="470 745 1039 913"> <thead> <tr> <th>Size (mm)</th> <th>Carton Kg</th> <th>Canister Kg</th> <th>Rods per Packet</th> </tr> </thead> <tbody> <tr> <td>3.2 x 450</td> <td>19.5</td> <td>6.5</td> <td>163</td> </tr> <tr> <td>4.0 x 450</td> <td>19.5</td> <td>6.5</td> <td>104</td> </tr> </tbody> </table>	Size (mm)	Carton Kg	Canister Kg	Rods per Packet	3.2 x 450	19.5	6.5	163	4.0 x 450	19.5	6.5	104
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<p>ADDITIONAL INFORMATION</p>	<p>Pre-heating of mild and medium Carbon steel base materials 100-200°C will ensure freedom from weld metal cracking. Low alloy, Carbon steel base materials should be pre-heated to 150-400°C, depending on their composition and thickness, to ensure freedom from weld metal cracking.</p>												

Our products, and any recommended practices, should be tested by the user under actual service conditions to determine their suitability for any particular purpose. The results obtained using this product/information are affected by variables such as welding procedure, base material composition, operating temperature, weldment design, method of fabrication and service requirements which are beyond our control. It is the sole responsibility of the user to determine the serviceability of a structure using this product and the information contained in this data sheet.