

DUR E 400 CrMo

CATEGORY SMAW Stick Electrodes

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

APPLICATIONS Hardfacing, rebuilding, overlays, machine parts, wheels, conveyors, crossings, bufferlayers prior to hardfacing etc

PROPERTIES Outstanding alloy against high impact combined with abrasion including metal to metal friction and increased working temperatures upto 550°C. Due to the high resistance to cracking and toughness, all weld metal requires no buffer layer except on materials considered critical. Suited for wear parts subject to heavy impact and shock. The weld metal is machinable with carbide tip tools, hardening is possible. The maximum hardness is dependent on the base metal and is often achieved in the first layer.

CLASSIFICATION

AWS	A 5.13: no class
EN ISO	14700: no class
DIN	8555: E3-UM-40 PT

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

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Si	Mn	Cr	Mo
0.1	0.4	0.6	6-7	3.0-3.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Hardness HRc		
				1st layer	2nd layer	3th layer
AW				36	39	42

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A) (DC+/AC)	kg / can	kg / 6 pack	kg / 1000
3.2	350	95-150	2.8	16.8	
4.0	350	140-180	3,2	19,2	
5.0	450	190-250	3,4	20.4	

REDRYING TEMPERATURE 300-320°C/2hr