

## 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	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	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		kg / can	Packing	
	Length (mm)	Current (A)		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