

SUPRADUR 400B is a thick basic-coated MMA electrode for depositing highly wear resisting hard facing deposits against sliding impacts.

Surfacing of rails up to 1080/mm² Tensile Strength. Typical applications includes: rails, rail crossings and switch points, wearing components such as dredger parts, bearing surfaces, striking tools, forging dies, buckstays, wheel flanges, slide surfaces subject to heavy wear, reconditioning of dies and punches slideways, shock, e.g. cams and rolling impact, e.g. rotors and rails.

Used for hard facing carbon steels and low alloy steels against sliding impacts. Weld metal hardness~ 375-450HB can only be machined by using sintered hard metal tools. Multi-layer deposits will be free of cracks, even without intermediate buffer layers. When welding crack sensitive base materials a buffer layer is required using more ductile C-Mn material or 307 type MMA electrode. Excellent weldability in all position except Vertical Down and Overhead positions. Shall be used in DC+ or AC current.

Classification	
EN	14700: E Fe1
DIN	8555: E1-UM-400

Approvals	Grade
DB	●

Chemical analysis (Typical values in %)

C	Mn	Si	Cr	Fe
0.2	0.4	0.7	2.7	Rem

All-weld metal Mechanical Properties

Heat Treatment	Hardness
As Welded ,No pre-heating / Interpass temperature < 100°C	375-450 HB
As Welded , Pre-heating / Interpass temperature 200 ± 25°C	320-360 HB

Materials

Electrode pour recharger la bande de roulement des rails jusqu'à une Rm = 1080 MPa

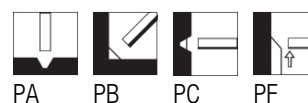
Storage

Keep dry and avoid condensation.

Re-drying recommended at 300-350°C for 2 hours, 5 times max.

Current condition and welding position

AC; DC+



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weightn(kg/1000)	CBOX	
				PC	Code
3.2	350	105-135	34.7	135	W000258528
4.0	450	120-180	69.9	85	W000258529
5.0	450	170-240	110.6	50	W000258530