

SUPRADUR 400B

TOP FEATURES

- Weld metal hardness~ 375-450HB can only be machined by using sintered hard metal tools.
- Excellent weldability in all position except Vertical Down and Overhead positions.
- Shall be used in DC+ or AC current.

CLASSIFICATION

EN 14700 E Fe1

CURRENT TYPE

AC, DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

DB

+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Fe
0.2	0.4	0.7	2.7	Rem

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition*	Hardness (HB)
EN 14700	AW	150-450
Typical values	AW, Nph/It < 100°C	375-450
	AW, Ph/It 200 ±25°C	330

* AW = As welded

Nph = No pre-heating

Ph = Pre-heating

It = Interpass temperature

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	105-135
4.0 x 450	120-180
5.0 x 450	170-240

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 350	CBOX	135	4.7	W000258528
4.0 x 450	CBOX	85	5.8	W000258529
5.0 x 450	CBOX	50	5.6	W000258530

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.