

# SAFER B 400

## 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 ISO 14700 E Fe1

## CURRENT TYPE

DC+

## WELDING POSITIONS

Flat/Horizontal

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

C	Mn	Si	Cr
0.21	<0.9	<0.45	1.9

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Hardness (HB)
EN ISO 14700	AW	150-450
Typical values	AW	375-450

\*AW: As-welded

## OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 450	120-140
4.0 x 450	160-190

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 450	CBOX	117	5.5	W000380871
4.0 x 450	CBOX	81	5.5	W000380874

## 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](http://www.lincolnelectric.eu) for any updated information.