

SAFER R 400

TOP FEATURES

- Weld metal hardness of ~240 – 290 HV1 0 in the as-welded condition, it can reach 400 HV after water-quenching. Deposit a maximum of 3 layers.
- Excellent weldability in all position except Vertical Down.
- Shall be used in DC- or AC mode.

CLASSIFICATION

EN ISO 14700-A E Fe1

CURRENT TYPE

AC, DC-

WELDING POSITIONS

All position, except vertical down

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

C	Mn	Si	Cr	Fe
0.1	0.6	0.3	2.4	bal.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Hardness (HB)
EN ISO 14700	AW	150-450
Typical values	AW	240-290

*AW: As-welded

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 450	100-135
4.0 x 450	120-170
5.0 x 450	150-220

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
3.2 x 450	CBOX	165	6.3	W000258788
4.0 x 450	CBOX	120	6.8	W000258789
5.0 x 450	CBOX	85	7.3	W000258790

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.