

Thick basic-coated MMA electrode for producing highly wear resisting hard facing deposits. Weld metal can be machined only by using sintered hard metal tipped tools. It is particularly resistant to impact and shock. A tough buffer layer using Univers or Citochromax N electrodes is solely required in case of very crack sensitive base metal. Even multi layers can be deposited without the need for intermediate buffer layers. Supradur 400B can be welded in all positions, except vertically-down. Suitable for reconditioning of rails, rail crossings and switch points, wearing parts such as dredger parts, bearing surfaces, striking tools, wheel flanges, slide surfaces subject to heavy wear, reconditioning of dies and punches.

Classification	
DIN	8555: E 1 - UM - 400
EN	14700: E Fe1

Approvals	Grades
DB	

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.20	0.40	0.50	-	-	2.80	-	-	-	Rem	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J)	Hardness
As Welded	-	-	-	-	375-450 HB

Materials

Rails up to grade 900/ tensile strength max. 1080 N/mm²

Storage and redrying

Keep dry and avoid condensation.

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

Current condition and welding position

DC+; AC



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
3,2	350	105-135	35,1	23,1
4,0	450	120-180	68,2	47,2
5,0	450	170-240	107,5	73,0