

CARBODUR 400

International Standards	DIN 8555	E 1-UM-400-P
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Approvals ---

Characteristics CARBODUR 400 is an AC-weldable electrode with approximately 120 % recovery for tough and wear resistant surfacing on equipment parts and tools which are subject to medium wear only. The dense and crack-free deposit is resistant to medium friction and compression and highly resistant to shocks.

Due to its soft fusion and low spattering the electrode can be used for welding in constrained positions. In spite of its basic coating it is well suitable for AC-welding. The weld metal can be machined with metal-cutting tools. Furthermore, surface layer hardening can be performed on machined areas.

A buffer layer of CARBO B 10 is recommended on base materials susceptible to work hardening.

Operating temperature

Typical applications Mainly used for heavy build up and as a cushion layer on crane wheels, shafts, slide ways, wheel rims, conveyor screws, and bars..

Hardness of all-weld metal (typical values)	HB
	ca. 400

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr	Mo
	0,15	0,7	1,5	5,2	0,75

Current = + / ~ 65 V

Welding positions PA, PB, PC, PD, PE

Rebaking 1 h, 200°C + / - 10 °C (if required)

Flux-cored wire equivalent	CARBO F- 400
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Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2.5 x 350	60 - 90	237	948	21.1	5.0	20.0
3.2 x 450	80 - 120	131	523	45.9	6.0	24.0
4.0 x 450	110 - 160	86	345	69.5	6.0	24.0
5.0 x 450	150 - 200	55	221	108.5	6.0	24.0

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