

ETC PH400 SUPRADUR 400



MMA Electrodes Hardfacing

SUPRADUR 400 is a thin rutile coated MMA electrode for hardfacing applications, which is very easy to use. Weld metal hardness of ~240 - 290HV10 in the as-welded condition, it can reach 400HV after water-quenching. Deposit a maximum of 3 layers. Used for surfacing against sliding impact, e.g. slideways, shock, e.g. cams and rolling impact, e.g. rotors. Typical applications are civil works and agricultural equipment such as crane parts, rails, slideways, rope pulleys, track-supporting rollers of crawler-type vehicles, wheel flanges and stud links.

Classification

EN 14700: E Fe1

Chemical analysis (Typical values in %)

C	Si	Cr	Fe
0.1	0.3	2.4	Rem.

All-weld metal Mechanical Properties

Heat Treatment	Hardness
As Welded	240-290 HV10

Storage

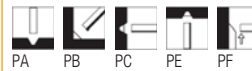
Keep dry and avoid condensation.

Re-drying not generally required.

If necessary: 150-200 °C for 2 hours, 5 times max.

Current condition and welding position

AC; DC-



Packaging data

Diam. (mm)	Length (mm)	Current (A)	Approx. weight (kg/1000)	BOX	
				PC	Code
3.2	450	100-135	38.3	160	ETC PH40032
4.0	450	120-170	56.8	115	ETC PH40040
5.0	450	150-220	86.3	80	ETC PH40050

