



# HARD ALLOY-400

## HARD SURFACING ELECTRODE

**CHARACTERISTICS :** A rutile type electrode developed for hard surfacing of steels subjected to wear due to impact and abrasion. Very stable arc and smooth transfer of alloying elements to weld deposit ensures completely crack free and sound weld metal. The weld metal is air hardening type and gives 350 to 450 BHN hardness.

**APPLICATIONS :**

- \* Shovels
- \* Conveyor Parts
- \* Gears
- \* Pulveriser Rolls
- \* Crawler Pads
- \* Shear Blades
- \* Forging Dies
- \* Plough Shears
- \* Punching Dies

**RECOMMENDATIONS :** Use stringer bead technique and avoid high currents. Short arc ensures proper alloy transfer to weld deposit. In case of reconditioning of heavily worn out part give a buffer layer with our MODI-7018 electrode.

**CHEMICAL ANALYSIS OF WELD-METAL (%) :**

	C	Mn	Si	Cr
	0.20-0.40	0.40-0.80	0.6 max	2.50-3.00

**HARDNESS :** On three layer deposit : 350-450 BHN

**CURRENT CONDITIONS : USE AC (50V) OR DC (-)**

Size (mm)	2.5x350	3.15x350 3.15x450	4.0x450	5.0x450	6.3x450
Amps	70-100	100-130	140-180	190-230	240-280



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