

Hardfacing electrode resistant to Impact, compression and abrasion

STARBLAZE HF 400 LH

Classification

DIN 8555: E1-UM-350P

Description and applications

Basic coated all position hard surfacing electrode for depositing Chromium manganese alloy weld metal for resisting moderate abrasion and impact. Recommended for surfacing of parts subject to wear by friction and mild impact. Rolling and sliding surfaces subject to heavywear, Carbon alloyed rails, dies, striking tools etc. Ideally suitable for construction and mining machinery parts like drive sprockets, rollers, concrete mixer blades, pump shafts, conveyor screws etc. Weld deposit is machinable with good cutting tools.

Typical weld metal Chemical Composition (%)

C	Si	Mn	Cr	Fe
0.20	0.40	0.50	2.80	Rem

All weld metal mechanical properties (typical)

Hardness
30- 35 HRc

Obtained in pure weld metal

Amperes (A)




3.15mm	4.00mm	5.00mm
80-110	120-160	150-200

Welding Instruction

Keep dry and avoid condensation. Re-dry generally not required, if necessary re-dry electrodes at 300-350°C for 1-2 hrs.

Clean the surface thoroughly. Remove all cracked and spalled metal. Use short arc and stringer beads. Weld 2-3 layers and finish weld metal by machining.

Welding Positions

				= + ~ 70V
PA	PB	PC	PF	

Stellaris Specialities India Ltd.

(Division: StarBlaze India)

GST No.: 06AAICS2482B1ZK / Legal Metrology No.: GOI/DL/2022/4850

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