

EZ - 400 TN

CLASSIFICATION

EN 14700	DIN 8555
E Fe 1	E1-UM-400

DESCRIPTION AND APPLICATION

A basic heavily coated electrode for medium-hard and wear resisting buildups. The deposit is machinable and resistant to abrasive wear abrasives which hardness is up to 140 HV. When hardfacing apply medium welding current and no weaving of electrode is recommended.

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

Hardness HB
375 - 450

APPROXIMATE CHEMICAL COMPOSITION OF THE ALL-WELD METAL

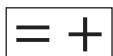
	C	Mn	Si	Cr
%	0,2	2,0	1,0	1,2

RECOMMENDED WELDING CURRENT

Ø mm	3,2	4,0	5,0	6,0
A	110 - 130	150 - 170	200 - 240	250 - 290

PACKAGING

Electrode dimensions mm	Quantity per ton approx. pieces	Weight of packaging kg
Ø 3,2 x 350	28 400	3,7
Ø 4,0 x 450	15 000	5,0
Ø 5,0 x 450	10 000	5,2
Ø 6,0 x 450	7 100	5,5



Marking: **EZ - 400 TN**