

PRODUCT DATA SHEET

Afrox 400

Afrox 400 is a rutile coated, AC/DC electrode depositing a tough chromium manganese alloy weld metal with a hardness of 320-400 HV (32-40 HRc). The weld deposit is hard enough to resist serious deformation under fairly heavy impact and rolling loads, yet has good resistance to mild abrasive wear. The electrode has a smooth soft arc with low spatter volume and can be used in all positions.

Applications

Afrox 400 is suitable for metal-to-metal wear applications involving abrasion and/or impact loads. The electrode is recommended for applications where maximum hardness consistent with reasonable machinability is required (machinable with carbide-tipped tools only). Typical applications include tractor idlers, track rolls, dragline pins, drive sprockets and gears, cable sheaves, hot metal or slag ladle pins, etc. The low open circuit voltage allows this electrode to be used on small AC machines.

Classifications

DIN	8555	EI-UM-350-P
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Typical Chemical Analysis (All weld metal)

% Carbon	0,1 - 0,2	% Chromium	2,4 - 4,0
% Manganese	0,3 - 1,0	% Molybdenum	0,1 max
% Silicon	0,5 - 1,0		

Typical Hardness

HRc	37 - 47
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Packing Data

(AC DC- 50 OCV min)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
4,0	350	120 - 160	5,0	W075634

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