

ES 400

SMAW

ESWECO
The Art of Welding

Type Rutile basic

E 1-UM-400-G

Description

ES 400 is a rutile basic coated electrode that produces a machinable martensitic deposit if weld metal is not quenched, designed for rolling, sliding and metal to metal wear resistance.

Low spatter, and the electrode can be used with the drag or contact welding technique as well as out of position. It gives a weld metal that is resistant to deformations of high rolling forces including metal to metal friction. Weld metal is airhardenable and can be machined with carbide cutting tools.

Hardness varies with respect to the number of passes and cooling rate.

Re-drying is 300 °C for min.2 hour.

Current

DC+, AC OCV 70V



Classifications

EN 14700

DIN 8555

E Z Fe1

E 1-UM-400-G

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.2	0.6	0.6	4.1	0.52

Typical mech. Properties all weld metal

Hardness, HRC 39-45

Welding parameters

Diameter,mm	Length,mm	Welding current, A	Arc voltage, V
3.2	350	110-140	30
4.0	450	150-190	31
5.0	450	190-260	32