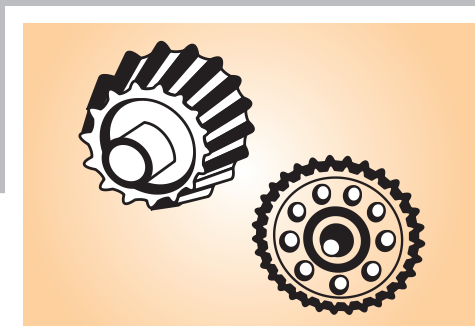


# ESSEN® DUR 400 KB

AC/ DC +

DIN 8555 E 1 - UM - 450 GP

An Electrode for Excellent Toughness, Impact Resistance & Resistance to Deformation.



## PROPERTIES

This is an all position electrode with alloy deposit having resistance to severe impact & deformation. Suitable for any ferrous parts subject to heavy shocks & loading. The weld deposit can be easily machined either in the as-welded condition or tempered condition. It can be hardened after this. Multiple layers are possible without slag removal

## MECHANICAL PROPERTIES

32 - 37 RC

## APPLICATIONS

For built up or buffer layers on gears, pinions, C.S. couplings, tail bars of sugar Mills, Crusher jaws, Hammers, Sprockets, Rollers, etc.

## WELDING PROCEDURE

Clean weld area. Preheating of heavy sections may be necessary. Use stringer or weaving technique holding a short to medium arc with electrode angle of 60°. Peeniing can be done to relieve stresses, Multiple layers possible without slag removal. Long deposits can be made without danger of cracking, avoid excessive heat built up. Allow to cool slowly.

RECOMMENDED AMPERAGE	
Size	Current
3.15 mm x 350 mm	100 - 160 Amps
4.00 mm x 350 mm	130 - 180 Amps

PACKING	
3.15 mm x 350 mm 5 kg	30 pcs/kg (Approx.)
4.00 mm x 350 mm 5 kg	20 pcs/kg (Approx.)



**ESSEN**  
WELDING ALLOYS PVT. LTD.



**ESSEN & AZUCAR**  
PREMIUM WELDING ALLOYS

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