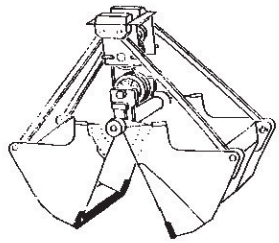
M A G N U M M 4 0 0

Economical hardfacing electrode for abrasion and moderate impact



- ❒ The best hardfacing electrode for low open circuit voltage AC welding machines.
- ❒ Spray transfer allows for smooth, uniform overlays.
- ❒ Hardness of RC 56-58 allows for good abrasion resistance along with moderate impact resistance.

INTERNATIONAL SPECIFICATIONS	AWS/ASME NONE DIN 8555 E6-UM-60-GP

APPLICATIONS:

General hardfacing where some impact is combined with abrasion.

MICROSTRUCTURE:

In the as-deposited condition, the microstructure consists of martensite and some carbides.

ALL WELD METAL ANALYSIS (Typical Weight %):

C	Mn	Si	P	S	Cr	Ni	Mo
.56	.95	.43	.018	.014	5.7	.03	.63

FLUX COLOR: Grey

TYPICAL MECHANICAL PROPERTIES:

Undiluted Weld Metal	Maximum Value Up to:
Hardness	Rockwell C56-58
Wear Co-efficient	2.8%

RECOMMENDED CURRENT: DC Reverse (+), AC

RECOMMENDED AMPERAGE SETTINGS:

Diameter (mm)	1/8(3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	150	200
Maximum Amperage	130	190	260

WELDING POSITIONS: Flat, horizontal

DEPOSITION RATES:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting	Recovery Rate
1/8 (3.25)	14" (350)	.9oz (26g)	18 (39)	23 (50)	110	130%
5/32 (4.0)	14" (350)	2.5oz (71g)	6 (14)	17 (37)	165	130%
3/16 (5.0)	14" (350)	3.7oz (105g)	4 (9)	13 (29)	230	130

WELDING TECHNIQUES:

Weld deposits are best applied using a weave technique. Full undiluted hardness is usually achieved after 2 to 3 passes.