



D&H 1400 (MOD)

CODIFICATION: AWS : SFA 5.11 ENiCrMo-4

CHARACTERISTICS AND APPLICATIONS:

Non-synthetic electrode for joining, repair and surfacing, to resist abrasion, corrosion, oxidation and high temperature service. Weld metal containing low carbon Cr-Mo-W-Co. Excellent resistance to heat, strength and toughness up to 1000°C. Weld metal has good thermal shock resistance, hardness retention even at elevated temperatures and work hardening characteristics. Ideal for welding low carbon Ni-Cr-Mo alloys, clad side of low carbon Ni-Cr-Mo alloys and alloys of similar composition. Ideal for valves, valve seats, impellers, guide points, bushing, bearing, journals, hot working tools like hot shear blades, forging dies, trimming dies, piercing punches etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	S	P	Cr	Ni	Mo	W	Fe	Co
Percent :	0.018	0.60	0.18	0.022	0.025	15.0	Balance	15.5	3.5	5.0	2.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	Elongation
(MPa)	(L=4d)%
720	28.0

CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	150-180	120-150	80-110	60-70
(Amps)					
Weight/Carton	:	2.5	2.5	2.5	2.5
(kgs)					

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300-325°C for one hour.
2. Use short arc, stringer bead, and smallest possible size of electrode and minimum current to reduce the heat input.