D&H 1400

CODIFICATION:

AWS : SFA 5.11 ENiCrMo-5
EN ISO : 14172 E Ni 6275

CHARACTERISTICS AND APPLICATIONS:

D&H 1400 is a nickel base electrode depositing a Ni-Cr-Mo-W-Co deposit. The weld deposit has excellent heat resistance and strength up to 1000°C. The deposit work hardens under impact load and the hardness is retained even at elevated temperatures. The deposit has high resistance to static or cyclic loads at high temperatures. Ideally suited for surfacing applications and joining applications to resist corrosion due to chloride environment and for surfacing of hot working tools, dies, punches, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Cr	Ni	Mo	W	Fe	Co
Percent :	0.05	0.60	0.50	15.0	balance	15.5	3.5	5.0	2.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L=5d)%
713	28.0

CURRENT AND PACKING DATA: DC(+)

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

APPROVAL: CE

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 300-325°C for one hour.
2. Use short arc and minimise heat input.
3. Clean the area thoroughly free from all contamination.
4. Wherever possible weld in flat position only.

info@dnhsecheron.net | www.dnhsecheron.com | +91 9833550505