



# PRODUCT DATA SHEET

## HARDFACING ELECTRODES

# PH400



### SUMMARY

- > A tough chromium-manganese alloy steel
- > Smooth running and easy to use
- > Easy release slag with virtually no spatter
- > Deposits little or no spatter

### IDENTIFICATION

**Coating** - Light Brown **Tip** - Yellow **Imprint** - PH400

### CLASSIFICATION

- > AS/NZS 2576 1435-A4

### DESCRIPTION AND APPLICATION

The iron powder in the PH400 electrode coating gives fast rates of deposition and allows the use of higher welding currents than normal. These electrodes are very smooth running and easy to use with either a short arc or the touch-weld technique, so that a minimum time is used to cover large areas. The slag releases very easily and there is virtually no spatter. Typical undiluted hardness 38Rc.

Tough chromium manganese alloy suitable for welding worn rails, shafts, grouser plates, shovel pads, track links, idler wheels, dragline pins etc.

### OPERATIONAL DATA

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	WELD CURRENT RANGE * (A)
3.2	380	95 - 145
4.0	380	125 - 180

\*Recommended for DC +/- or AC (minimum 50 OCV).  
Voltage is determined by arc current and electrode arc length.  
Arc voltage shown is typical and is only to be used as a guide.

### TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Cr
0.16	0.60	0.40	2.90

### TYPICAL ALL WELD METAL HARDNESS

Metal Hardness	35 - 39 RC
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### PACKAGING DATA

ELECTRODE SIZE (MM)	PACKAGING		APPROX. NO. OF RODS PER KG	PART NO.
	KG PER PACKET	PACKETS PER CARTON		
3.2	5.0	5	127	PH40032
4.0	5.0	5	68	PH40040

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Issue CA - May 2019