

# SUNALLOY 401

Electrode for medium-tensile, ductile steel welds



## DESCRIPTION

SUN ALLOY 401 is a special coated electrode high grade and crack resistant welds on hydrogen controlled steels and for construction subject to local stress accumulations. Suitable for fine grained steels of 20 mm (0.78") sheet thickness.

## ALLOY BASIS

Fe, C, Mn, Si

## PROPERTIES

The weld bead has good appearance and slag peels off easily. The weld metal is extremely ductile and resistant to cracking and of radiographic quality.

## APPLICATIONS

Major application of SUNALLOY 401 is for joining and building up of low and medium carbon steels. It is ideal for joining dissimilar sections, restrained joints and oil soaked parts. It can also be used as a cushioning alloy under hardfacing deposits. Finds applications in pressure vessels, pipes, flanges, vehicle chassis, cross members, gun plates, heavy machinery parts, steel castings, etc.

## TECHNICAL DATA & WELDING PARAMETERS

Size (diameter)/length (mm)	: 2.50 x 350	3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 70 - 100	110 - 140	160 - 190	220 - 240
Current	: AC/DC (+)			