

MAGNA 400

Magna Crusher Rod 400 was specifically designed for maximum service and ease of application on all types of crushing equipment.

So far as is known, no other electrode, whether cast, fabricated or an alloy coated wire - even at several times the price of Magna Crusher Rod 400 - can match the weldability and crusher service provided by this rugged duty Magna electrode.

This electrode is a culmination of years of experience observation and tests, and was three years in final formulation. It has the following special features:

- 1. Properties.** Rockwell C Hardness: 55
Resistance to Abrasion: Remarkable
Resistance to Impact: Good
Formulation: A high chrome super metal with the addition of rare earth compounds for refinement and the addition of special metals to provide an unprecedented shock absorbing quality. Few other electrodes in existence can provide the outstanding service on crushing equipment.
- 2. Weldability.** Excellent for both AC and DC. Has a highly efficient arc with no spatter and is slag free. The coating actually goes into the deposit and therefore substantially increases the amount of weld metal deposited. Has extremely high deposition rate.
- 3. Economy.** Magna Crusher Rod 400 is the most economical electrode ever designed for crushers. Most hard surface electrodes give about 18 kg. of deposit from 45 kg of electrodes because of stub loss, slag loss, spatter loss and smoking and fuming. Magna Crusher rod 400 is a most efficient hard surface electrode. It has no slag loss, no spatter loss and 45 kg of electrodes give nearly 44 kg of deposit. Most operators melt even the stubs into the deposit. When you buy a box of Magna Crusher Rod 400 you buy a deposit - not a box of slag like most electrodes.

4. End Uses. While Magna Crusher Rod 400 was designed for Crushers it will give excellent service wherever the job is similarly demanding. Some of the most important uses are:

Disintegration bars from combination roll crushers.	Agitator blades in machines.	Sheepsfoot tamps Impact breaker rotors and bars
Scarifier teeth	End bits	Grader blades
Skip hoists	Screens	Conveyor fans
Power shovel teeth	Conveyor buckets	

APPLICATION

Magna 400 can be applied to Carbon or Alloy Steels and Manganese Steel using either AC or DC welding machines (set to reverse polarity). As Magna 400 transfers smoothly, either a long or short arc may be used.

Apply by making non-connecting deposits over entire area to be coated. Then weld additional passes to fill in between these original deposits. Up to two layers of the electrode may be made.

Where more than two layers are required, an initial coating of Magna 402 will give a superior result.

Welds of Magna 400 Crusher Rod cannot be machined or heat treated.

Recommended Amperages:

Metric	Inches	Gauge	Setting
4.0 mm.	5/32	8	130 amps
4.8 mm.	3/16	6	175 amps