

OK Weartrade 55 HD



A general purpose hardfacing electrode depositing a semi corrosion resistant martensitic steel with a hardness of about 57 HRC. The electrode is specially suitable for hardfacing parts exposed to different forms of abrasive and impact wear, e.g. farming equipment, forestry tools, loading machines and mixers.

Classifications:	EN 14700:E Z Fe6
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Welding Current:	AC, DC+
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Alloy Type:	Martensitic steel
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Coating Type:	Lime Basic
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Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.67	0.7	0.7	10.4

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	75-110 A	23 V	0.67	58	62 s	1.0 kg/h
3.2 x 450 mm	110-150 A	23 V	0.67	27	95 s	1.4 kg/h
4.0 x 450 mm	145-200 A	24 V	0.67	18	107 s	1.9 kg/h
5.0 x 450 mm	190-270 A	26 V	0.66	12	110 s	2.8 kg/h