

# OK Weartrode 55



Heavy coated general purpose hardfacing electrode for worn parts where a hardness level of minimum 50 HRC is required.

<b>Classifications:</b>	EN 14700:E Z Fe3
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<b>Welding Current:</b>	DC+
<b>Alloy Type:</b>	Martensitic
<b>Coating Type:</b>	Basic

## Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.5	0.6	1.4	5.7

## 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
3.2 x 450 mm	100-130 A	23 V	0,65	46	72,8 s	1,1 kg/h
4.0 x 450 mm	130-180 A	24 V	0,64	24	107 s	1,4 kg/h
5.0 x 450 mm	180-220 A	24 V	0,64	15	126 s	1,9 kg/h
6.0 x 450 mm	210-270 A	25 V	0,66	10,3	140 s	2,5 kg/h