

OK Autrodur 58 G M

OK Autrod 13.90 is a copper-coated, low-alloyed, solid GMAW wire used for hardfacing and building up highly wear-resistant layers on machinery parts like shafts, feed screws, driving rollers, cutting tools, dies and other parts subjected to heavy wear. The hardness of the weld metal becomes 50-60 HRC.

Classifications Wire Electrode:	EN 14700:ZFe8
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Alloy Type:	Low alloyed (1.1 % C, 2 % Mn, 1.8 % Cr, 0.2 % Ti)
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Typical Wire Composition %			
C	Mn	Si	Cr
1.04	1.87	0.48	1.82

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	80-280 A	18-28 V	2,7-14,7 m/min	1-5,4 kg/h
1.2 mm	120-350 A	20-33 V	2,7-12,4 m/min	1,5-6,6 kg/h