

OK Tubrodur 13Cr S

OK Tubrodur 13Cr S is a cored wire which produces a 13%-chromium alloy steel deposit used with OK Flux 10.37 or OK Flux 10.61.

Classifications Weld Metal:	EN 14700:T Fe7
Approvals:	NAKS/HAKC 3.0mm

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Alloy Type:	Surfacing alloy: martensitic stainless steel weld metal

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
2.4 mm	250-450 A	28-38 V	2.0-5.0 m/min	4.0-9.0 kg/h
3.0 mm	400-700 A	28-36 V	2.5-5.5 m/min	5.5-12.0 kg/h

OK Tubrodur 13Mn O/G

OK Tubrodur 13Mn O/G is a self-shielded, flux-cored wire of the austenitic-manganese type. The work hardening characteristics and extremely tough crack-resistant weld metal ensure that OK Tubrodur 13Mn O/G is the ideal solution for rebuilding 13Mn steels, normally found in crusher jaws, swing hammers and numerous parts of earth-moving, mining and quarrying equipment.

Classifications Weld Metal:	EN 14700:T Fe9
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Welding Current:	DC+
Alloy Type:	13% manganese steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Al
0.85	11.78	0.63	2.95	0.38

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-260 A	24-30 V	2.0-4.2 m/min	2.5-3.2 kg/h