

OK Tubrodur 15CrMn O/G

OK Tubrodur 15.65 is a flux-cored wire for self- or CO₂ shielding, depositing a martensitic-austenitic, work-hardening deposit. OK Tubrodur 15.65 can be used for the rebuilding of mild, low-alloy and 13Mn steels. The weld metal combines excellent abrasion and impact resistance and is suitable for applications such as crusher jaws and hammers, railway point frogs, ripper teeth and wear plates.

Classifications Weld Metal:	EN 14700:T Fe9
Approvals:	CE EN 13479, DB 82.039.10

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

Welding Current:	DC+
Alloy Type:	14% Mn 14%Cr steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	V
0.3	13.5	0.5	1.75	16.0	0.8	0.65

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-250 A	28-37 V	6.5-21.5 m/min	3.3-7.2 kg/h
1.6 mm	200-330 A	24-33 V	5.0-12.0 m/min	3.7-8.0 kg/h

OK Tubrodur 23Cr S

A tubular electrode for submerged arc welding with OK Flux 10.92. This electrode produces a weld metal with the following composition: 22% chromium, 4% nickel and 1% molybdenum. The weld metal is oxidation and heat resistant.

Applications: This electrode is suitable for a wide range of components subjected to corrosive media or high-temperature conditions. Examples include shafts, axles, wheels, rollers and so on which are subject to wear by corrosion-oxidation processes. It can be used as a buffer layer on high carbon-base material, prior to hardfacing with high carbon deposits.

Classifications Weld Metal:	EN 14700:T Fe7
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Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.04	0.23	0.77	4.0	23.4	1.3

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
3.0 mm	400-700 A	28-36 V	2.5-5.5 m/min	5.5-12.0 kg/h