

OK Tubrodur 200 O D

A stainless, 18.8.6Mn, self-shielded, tubular wire for cladding and joining 13% Mn steels and steels with limited weldability. It is also useful for buffer layers prior to hardfacing.

Classifications Weld Metal:	EN 14700:T Fe10
------------------------------------	-----------------

Welding Current:	DC+
Alloy Type:	Austenitic Cr-Ni-Mn weld metal

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Cr
0.026	5.12	0.48	8.7	19.1

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-450 A	21-40 V	2.4-11.9 m/min	1.8-9.0 kg/h