

OK Tubrodur 35 O M

OK Tubrodur 35 O M is a self-shielded, flux-cored, tubular wire, primarily developed for the on-site rebuilding of worn CMn railway and tram tracks. The weld deposit is of the CrNiMo type and has excellent compressive strength with a hardness of 30-40 HRC.

Classifications Weld Metal:	EN 14700:T Z Fe3
Welding Current:	DC+
Alloy Type:	Surfacing alloy: martensitic steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Al
0.14	1.10	0.28	2.23	1.04	0.48	1.5

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	150-300 A	25-36 V	5.0-12.6 m/min	2.4-6.8 kg/h

OK Tubrodur 35 S M

OK Tubrodur 15.40S is a flux-cored wire for SAW hardfacing in conjunction with OK Flux 10.71, depositing a manganese-chromium-molybdenum-alloyed weld metal with a hardness of 32-36 Rockwell C. Suitable for surfacing wheel runners, track links, wheels and rollers for conveyor belts, wheels for mine trucks, rolls and shafts, where a hardness within the range of 32-40 Rockwell C is desired. With negative polarity, less heat input to the base material, less dilution of the weld metal and a higher deposition rate are obtained. In most cases, surfacing with OK Tubrodur 15.40S can be performed without preheat. The need for preheat and increased interpass temperature is determined by the weldability of the parent material in question and the form and dimensions of the workpiece. Whenever possible, surfaced axles and similar objects, which are exposed to a bending stress during rotation, should always be stress relieved at 500-600°C.

Classifications Weld Metal:	EN 14700:T Fe1
Welding Current:	DC+
Alloy Type:	Martensitic steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.21	1.40	1.10	1.47

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
4.0 mm	500-900 A	28-34 V	2.0-5.0 m/min	6.5-12.5 kg/h