

OK Tubrodur 40 O M

OK Tubrodur 15.42 is a self- or CO₂-shielded, flux-cored wire for GMAW hardfacing. It is designed for surfacing wheel runners, track links, billet rolls, wheels and rollers for conveyor belts, wheels for mine trucks, rolls and shafts, where a hardness of 35-45 HRC is desired.

Classifications Weld Metal:	EN 14700:T Z Fe2
Welding Current:	DC+
Alloy Type:	Martensitic steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Al
0.14	1.59	0.62	0.55	4.64	0.49	1.55

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-300 A	25-36 V	5.0-12.6 m/min	2.4-6.8 kg/h

OK Tubrodur 40 S M

A tubular hardfacing wire for rebuilding and surfacing using the submerged arc welding process.

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

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
OK Flux 10.71				
0.15	1.14	0.51	4.07	0.77

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