

OK Wearode 45



Heavy coated general purpose hardfacing electrode for worn parts providing a hardness level of approximately 45 HRC.

Classifications:	EN 14700:E Z Fe3
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Welding Current:	DC+
Alloy Type:	Martensitic
Coating Type:	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.3	2.0	0.8	1.3

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
3.2 x 450 mm	100-130 A	24 V	0,63	35,3	94 s	1,1 kg/h
4.0 x 450 mm	130-180 A	26 V	0,6	25	105 s	1,4 kg/h
5.0 x 450 mm	180-220 A	25 V	0,64	15,4	124 s	1,9 kg/h