

OK Weartrode 50 T



OK Weartrode 50 T is primarily used for surfacing objects that are exposed to impact, metal to metal and pressure in environments up to 400 °C i.e. dies, cog wheels, cutting edges and press tooling.

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|-------------------------|------------------|
| Classifications: | EN 14700:E Z Fe8 |
| Welding Current: | DC+ |
| Alloy Type: | C, Mn, Si, Cr |
| Coating Type: | Basic |

Typical Weld Metal Analysis %

| C | Mn | Si | Cr |
|------|-----|-----|------|
| 0.20 | 0.6 | 0.3 | 12.7 |

Deposition Data

| Diameter | Current | kg weld metal/kg electrodes | Number of electrodes/kg weld metal | Fusion time per electrode at 90% I max | Deposition rate 90% I max |
|--------------|-----------|-----------------------------|------------------------------------|--|---------------------------|
| 2.0 x 300 mm | 50-70 A | 0.63 | 125 | 56 s | 0.5 kg/h |
| 2.5 x 350 mm | 60-80 A | 0.59 | 77 | 55 s | 0.9 kg/h |
| 3.2 x 450 mm | 90-110 A | 0.71 | 34 | 80 s | 1.3 kg/h |
| 4.0 x 450 mm | 140-160 A | 0.71 | 22 | 106 s | 1.6 kg/h |
| 5.0 x 450 mm | 180-200 A | 0.71 | 14 | 112 s | 2.3 kg/h |