

OK Weartrode 60 T



Electrode producing a weld metal with coarse chromium carbides in an austenitic matrix. Suitable for surfacing worn parts exposed to abrasion and wear by coal, ore or other minerals. Typical applications include earth-moving machines, mixers, feeder screws, dust exhausters and crushers. It can also be used on components operating in corrosive environments and/or at elevated temperatures.

Classifications:	EN 14700:E Z Fe14		
Welding Current:	AC, DC+		
Alloy Type:	Carbide rich steel		
Coating Type:	Rutile Basic		

Typical Weld Metal Analysis %						
С	Mn	Si	Cr			
4.8	1.0	0.7	34.3			

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	
2.5 x 350 mm	90-120 A	24 V	0.62	48	60 s	1.2 kg/h	
3.2 x 350 mm	115-170 A	24 V	0.62	26	85 s	1.6 kg/h	
4.0 x 450 mm	130-210 A	26 V	0.64	14	135 s	2.0 kg/h	
5.0 x 450 mm	150-300 A	26 V	0.64	9	140 s	2.9 kg/h	