

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 | |