

OK Weartrode 60



Electrode for hardfacing parts of dredgers, feed screws, crusher and tractor parts exposed to wear by stone, coal, sand, soil, etc. The weld metal presents a relatively good resistance to oxidation, also at elevated temperatures.

Classifications:	EN 14700:E Z Fe2
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Welding Current:	AC, DC+
Alloy Type:	Martensitic steel
Coating Type:	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.80	0.4	4.5	2.0

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	100-140 A	23 V	0.68	34	87 s	1.2 kg/h
4.0 x 450 mm	140-190 A	25 V	0.68	22	90 s	1.8 kg/h