

OK Weartrode 62



A hardfacing electrode depositing a weld metal with a high volume fraction of fine carbides in a martensitic matrix.

It is designed for protection of parts subjected to severe abrasion from rock, sand, cement, etc.

Applications: earth-drilling equipment, hammers, scrapers, knives, conveyor screws, etc.

Welding Current:	AC, DC+-
Alloy Type:	Carbide rich steel
Coating Type:	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr	V	Ti
2.9	0.4	1.9	6.2	5.2	4.9

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	70-100 A	17 V	0.63	71	105 s	0.5 kg/h
3.2 x 350 mm	100-150 A	17 V	0.60	44	110 s	0.7 kg/h
4.0 x 350 mm	115-200 A	17 V	0.64	27	120 s	1.0 kg/h