

OK Wearrode 65 T



The electrode deposits a high density of wear resisting carbides in an austenitic matrix capable of resisting extreme conditions of abrasion up to 700°C. Recovery approximately 220%. Typical applications include exhaust fans, ash ploughs, conveyor screws and sinter plant components.

Classifications:	EN 14700:E Fe16
Welding Current:	DC+
Alloy Type:	Austenitic iron
Coating Type:	Special

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V	Nb	W
6.0	0.7	1.9	24.5	6.6	0.8	5.4	1.7

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 350 mm	150-170 A	22 V	0.72	22	132 s	1.2 kg/h
4.0 x 350 mm	220-250 A	23 V	0.71	15	123 s	2.0 kg/h