

OK Weartrode 40



OK Weartrode 40 is used in applications exposed to metal to metal wear. A common application is surfacing wear resistant dies operating at temperatures up to 400°C.

OK Weartrode 40 provides a weld metal with minimum hardness level of 40 HRC, typical value is around 45 HRC.

Classifications:	EN 14700:E Z Fe2
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Welding Current:	DC+
Alloy Type:	C, Mn , Si, Cr, V
Coating Type:	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V
0.20	0.9	0.4	2.0	0.5	0.5

Deposition Data

Diameter	Current	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	90-110 A	0.59	77	58 s	0.9 kg/h
3.2 x 450 mm	90-130 A	0.71	34	97 s	1.1 kg/h
4.0 x 450 mm	160-180 A	0.67	22	112 s	1.4 kg/h
5.0 x 450 mm	170-220 A	0.71	14	127 s	2.0 kg/h