

OK Weartrode 30

Electrode depositing a low alloy steel for the protection of parts exposed to metallic wear. Typical application include rail and rail crossing section, cog wheels of cast steel, detail in rolling mills, e.g. grooved rollers and clutches. Weld metal hardness approximately 30 HRC.

Specifications

Classifications	EN 14700 : E Z Fe1
Approvals	DB : 82.039.07

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Lime Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.1	0.7	0.7	3.2

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	60-90 A	20 V	64 %	75 sec	0.7 kg/h
3.2 x 450.0 mm	100-140 A	21 V	66 %	88 sec	1.2 kg/h
4.0 x 450.0 mm	140-190 A	22 V	66 %	92 sec	1.7 kg/h
5.0 x 450.0 mm	190-260 A	23 V	68 %	86 sec	2.8 kg/h
6.0 x 450.0 mm	230-320 A	23 V	68 %	92 sec	3.7 kg/h