

OK Tubrodur 53 G M

A cored wire which produces a Cr-Mo-V-Co-W alloyed weld metal for hardfacing used with C1 shielding gas.

Specifications

Classifications	EN 14700 : T Fe3 DIN 8555 : MF3-50T
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Welding Current	DC+
Alloy Type	Surfacing alloy Cr-Mo-V-Co-W
Shielding Gas	C1 (EN ISO 14175)

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V	Co	W
C1 shielding gas							
0.33	1.14	0.94	1.76	0.44	0.40	2.03	8.17

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-450 A	21-40 V	2.4-11.9 m/min	1.8-9.0 kg/h