

## OK Tubrodur 35 O M

A self-shielded cored wire which gives a Cr-Ni-Mo alloyed weld metal for rail surface repair.

### Specifications

|                        |                                               |
|------------------------|-----------------------------------------------|
| <b>Classifications</b> | EN 14700 : T Z Fe3                            |
| <b>Welding Current</b> | DC+                                           |
| <b>Alloy Type</b>      | Surfacing alloy: martensitic steel weld metal |
| <b>Shielding Gas</b>   | None                                          |

### Typical Weld Metal Analysis %

| C    | Mn   | Si   | Ni   | Cr   | Mo   | Al  |
|------|------|------|------|------|------|-----|
| 0.14 | 1.10 | 0.28 | 2.23 | 1.04 | 0.48 | 1.5 |

### Deposition Data

| Diameter | Amps      | Volts   | Wire Feed Speed | Deposition Rate |
|----------|-----------|---------|-----------------|-----------------|
| 1.2 mm   | 150-250 A | 28-37 V | 6.5-21.5 m/min  | 3.3-7.2 kg/h    |
| 1.6 mm   | 150-300 A | 25-36 V | 5.0-12.6 m/min  | 2.4-6.8 kg/h    |