

OK Weartrade 30 HD

High recovery electrode for cladding and hardfacing rails, rail points, crossings, wheel conveyors, rolls etc. Used in the same type of applications as OK Weartrade 30. Weld metal hardness approx. 30 HRC.

Specifications	
Classifications	EN 14700 : E Fe1

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

Typical Weld Metal Analysis %			
C	Mn	Si	Cr
0.1	0.8	0.7	3.0

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	110-180 A	26 V	67 %	66 sec	2.4 kg/h
4.0 x 450.0 mm	160-240 A	30 V	67 %	69 sec	3.4 kg/h
5.0 x 450.0 mm	230-330 A	42 V	68 %	73 sec	5.0 kg/h