

OK Tubrodur 23Cr S

A cored wire for submerged arc welding which produces a 22%Cr 4%Ni 1%Mo weld metal used under flux in the submerged arc process.

Specifications

Classifications	EN 14700 : T Fe7
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Alloy Type	Surfacing alloy: martensitic stainless steel weld metal
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Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.04	0.23	0.77	4.0	23.4	1.3

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
3.0 mm	400-700 A	28-36 V	2.5-5.5 m/min	5.5-12.0 kg/h