

OK Weartrade 50 T

OK Weartrade 50 T is primarily used for surfacing objects that are exposed to impact, metal to metal and pressure in environments up to 400 °C i.e. dies, cog wheels, cutting edges and press tooling.

Specifications

Classifications	EN 14700 : E Z Fe8
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Welding Current	DC+
Alloy Type	C, Mn, Si, Cr
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.20	0.6	0.3	12.7

Deposition Data

Diameter	Current	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	60-80 A	59 %	55 sec	0.9 kg/h
3.2 x 450.0 mm	90-110 A	71 %	80 sec	1.3 kg/h
4.0 x 450.0 mm	140-160 A	71 %	106 sec	1.6 kg/h