

OK Tubrodur 35 O M

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

Specifications

Classifications	EN 14700 : T Z Fe3
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Welding Current	DC+
Alloy Type	Surfacing alloy: martensitic steel weld metal
Shielding Gas	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	Current	Voltage	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