

## OK Tooltrode 60

Hardfacing electrode of the high-speed steel for repair welding of cutting tools, drills, stamping machines etc. The weld metal obtains its maximum hardness by double tempering. Suitable for step welding. To avoid issues with cracking, the working temperature should be preferably 400-500°C.

### Specifications

<b>Classifications</b>	EN 14700 : E Fe4
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<b>Welding Current</b>	AC, DC+
<b>Alloy Type</b>	Tool steel
<b>Coating Type</b>	Lime Basic

### Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V	W
0.93	1.4	1.4	4.7	7.3	1.60	1.39

### Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	80-110 A	23 V	55 %	67 sec	0.8 kg/h
3.2 x 350.0 mm	100-150 A	23 V	57 %	82 sec	1.1 kg/h
4.0 x 350.0 mm	120-190 A	25 V	58 %	97 sec	1.4 kg/h