

OK Tubrodur 40 S M

A tubular hardfacing wire for rebuilding and surfacing using the submerged arc welding process.

Specifications

Classifications	EN 14700 : T Z Fe1
Welding Current	DC+
Alloy Type	Martensitic steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
OK Flux 10.71				
0.15	1.14	0.51	4.07	0.77

Deposition Data

Diameter	Amps	Volts	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
4.0 mm	500-900 A	28-34 V	2.0-5.0 m/min	6.5-12.5 kg/h