

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

Classifications	EN 14700 : E Fe4
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Welding Current	AC, DC+
Alloy Type	Tool steel
Coating Type	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	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
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