

OK Tooltrode 50

Electrode for surfacing hot working tools. Suitable for service temperatures up to about 550 °C and applications where toughness and good wear resistance are required. Typical applications include hot working blades and shears, punches and bottom dies. Preheating and interpass temperature should be minimum 200°C to avoid issues with cracking.

Specifications	
Classifications	EN 14700 : E Z Fe3

Welding Current	AC, DC+
Alloy Type	High speed steel
Coating Type	Lime Basic

Typical Weld Metal Analysis %						
C	Mn	Si	Cr	Nb	Co	W
0.32	0.9	1.1	1.8	0.8	2.1	7.9

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	70-110 A	22 V	65 %	53 sec	0.9 kg/h
3.2 x 350.0 mm	100-150 A	23 V	63 %	62 sec	1.3 kg/h
4.0 x 350.0 mm	130-190 A	23 V	63 %	75 sec	1.7 kg/h
5.0 x 350.0 mm	180-250 A	25 V	66 %	88 sec	2.2 kg/h