

OK Weartrade 40

OK Weartrade 40 is used in applications exposed to metal to metal wear. A common application is surfacing wear resistant dies operating at temperatures up to 400°C. OK Weartrade 40 provides a weld metal with minimum hardness level of 40 HRC, typical value is around 45 HRC.

Specifications

| | |
|------------------------|--------------------|
| Classifications | EN 14700 : E Z Fe2 |
| Welding Current | DC+ |
| Alloy Type | C, Mn , Si, Cr, V |
| Coating Type | Basic |

Typical Weld Metal Analysis %

| C | Mn | Si | Cr | Mo | V |
|------|-----|-----|-----|-----|-----|
| 0.20 | 0.9 | 0.4 | 2.0 | 0.5 | 0.5 |

Deposition Data

| Diameter | Current | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
|----------------|-----------|----------------|----------------------------------------|-----------------|
| 3.2 x 450.0 mm | 90-130 A | 71 % | 97 sec | 1.1 kg/h |
| 4.0 x 450.0 mm | 160-180 A | 67 % | 112 sec | 1.4 kg/h |
| 5.0 x 450.0 mm | 170-220 A | 71 % | 127 sec | 2.0 kg/h |