

OK Weartrode 60

Electrode for hardfacing parts of dredgers, feed screws, crusher and tractor parts exposed to wear by stone, coal, sand, soil, etc. The weld metal presents a relatively good resistance to oxidation, also at elevated temperatures.

Specifications	
Classifications	EN 14700 : E Z Fe2

Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Basic

Typical Weld Metal Analysis %			
C	Mn	Si	Cr
0.80	0.4	4.5	2.0

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	100-140 A	23 V	68 %	87 sec	1.2 kg/h
4.0 x 450.0 mm	140-190 A	25 V	68 %	90 sec	1.8 kg/h