

OK Weartrode 35

This electrode is a hardfacing basic type yielding an as welded hardness of 300 HV. It combats metal to metal wear and slight abrasion. It is used mainly for surfacing worn train and tramway rails. Also for carbon manganese crossings. Other areas of use: Cog-wheels

Specifications

Classifications	EN 14700 : E Fe1
Welding Current	DC+
Ferrite Content	N/A
Alloy Type	C, Si, Mn, Cr
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.09	0.9	0.8	3.0

Deposition Data

Diameter	Current	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	110-140 A	77 %	84 sec	1.2 kg/h
4.0 x 450.0 mm	140-160 A	77 %	98 sec	1.6 kg/h
5.0 x 450.0 mm	180-200 A	77 %	100 sec	2.4 kg/h