

OK Wearode 55

Heavy coated general purpose hardfacing electrode for worn parts where a hardness level of minimum 50 HRC is required.

Specifications

Classifications	EN 14700 : E Z Fe3
Welding Current	DC+
Alloy Type	Martensitic
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.5	0.6	1.4	5.7

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	100-130 A	23 V	65 %	72,8 sec	1.1 kg/h
4.0 x 450.0 mm	130-180 A	24 V	64 %	107 sec	1.4 kg/h
5.0 x 450.0 mm	180-220 A	24 V	64 %	126 sec	1.9 kg/h
6.0 x 450.0 mm	210-270 A	25 V	66 %	140 sec	2.5 kg/h