

OK Wearode 55 HD

A general purpose hardfacing electrode depositing a semi corrosion resistant martensitic steel with a hardness of about 57 HRC. The electrode is specially suitable for hardfacing parts exposed to different forms of abrasive and impact wear, e.g. farming equipment, forestry tools, loading machines and mixers. Additional information is found under the heading "Other Data".

Specifications

Classifications	EN 14700 : E Z Fe6
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Welding Current	AC, DC+
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Alloy Type	Martensitic steel
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Coating Type	Lime Basic
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Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.67	0.7	0.7	10.4

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	75-110 A	23 V	67 %	62 sec	1.0 kg/h
3.2 x 450.0 mm	110-150 A	23 V	67 %	95 sec	1.4 kg/h
4.0 x 450.0 mm	145-200 A	24 V	67 %	107 sec	1.9 kg/h
5.0 x 450.0 mm	190-270 A	26 V	66 %	110 sec	2.8 kg/h