

OK Tubrodur 12Cr S

A cored wire which produces a martensitic 12%-chromium alloy steel deposit with nitrogen addition. Used under flux in the submerged arc process.

Specifications

Classifications	EN 14700 : T Fe7
Welding Current	DC+-
Alloy Type	Surfacing alloy: martensitic stainless steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	V	N	Nb
OK Flux 10.33								
0.05	0.86	0.51	3.88	11.9	1.02	0.10	0.061	0.11

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
3.0 mm	400-700 A	28-36 V	2.5-5.5 m/min	5.5-12.0 kg/h