

## OK Weartrode 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 |

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

| Typical Weld Metal Analysis % |     |     |      |
|-------------------------------|-----|-----|------|
| C                             | Mn  | Si  | Cr   |
| 0.67                          | 0.7 | 0.7 | 10.4 |

| Deposition Data |           |         |                |  |                 |
|-----------------|-----------|---------|----------------|--|-----------------|
| Diameter        | Current   | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 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        |