

## OK Weartrode 62

A hardfacing electrode depositing a weld metal with a high volume fraction of fine carbides in a martensitic matrix. It is designed for protection of parts subjected to severe abrasion from rock, sand, cement, etc. Applications: Earth-drilling equipment. Hammers, scrapers, knives, conveyor screws, etc.

|                        |                    |
|------------------------|--------------------|
| <b>Welding Current</b> | AC, DC+-           |
| <b>Alloy Type</b>      | Carbide rich steel |
| <b>Coating Type</b>    | Basic              |

| Typical Weld Metal Analysis % |     |     |     |     |     |
|-------------------------------|-----|-----|-----|-----|-----|
| C                             | Mn  | Si  | Cr  | V   | Ti  |
| 2.9                           | 0.4 | 1.9 | 6.2 | 5.2 | 4.9 |

| Deposition Data |           |         |                |                                        |                 |
|-----------------|-----------|---------|----------------|----------------------------------------|-----------------|
| Diameter        | Current   | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 3.2 x 350.0 mm  | 100-150 A | 17 V    | 60 %           | 110 sec                                | 0.7 kg/h        |
| 4.0 x 350.0 mm  | 115-200 A | 17 V    | 64 %           | 120 sec                                | 1.0 kg/h        |