

OK Wearode 30 HD

High recovery electrode for cladding and hardfacing rails, rail points, crossings, wheel conveyors, rolls etc. Used in the same type of applications as OK Wearode 30. Weld metal hardness approx. 30 HRC.

Specificaties

Classificaties	EN 14700 : E Fe1
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Lasstroom	AC, DC+
Legering Type	Martensitic steel
Coating Type	Zircon Basic

Typische lasmetaalanalyse (%)

C	Mn	Si	Cr
0.1	0.8	0.7	3.0

Neersmeltgegevens

Diameter	Ampère	Volt	Rendement (%)	Smelttijd per elektrode bij 90% I max	Neersmelt
3.2 x 450.0 mm	110-180 A	26 V	67 %	66 sec	2.4 kg/h
4.0 x 450.0 mm	160-240 A	30 V	67 %	69 sec	3.4 kg/h
5.0 x 450.0 mm	230-330 A	42 V	68 %	73 sec	5.0 kg/h