

OK Tubrodur 40 S M

OK Tubrodur 15.42S is a flux-cored wire for SAW hardfacing in conjunction with OK Flux 10.71, giving a CrMnMo-alloy deposit with an as welded hardness of 35-44 Rockwell C. OK Tubrodur 15.42S is designed for surfacing of wheel runners, track links, billet rolls, wheels and rollers for conveyor belts, wheels for mine trucks, rolls and shafts, where a hardness of 35-45 Rockwell C is desired.

Specificaties

Classificaties	EN 14700 : T Z Fe1
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Lasstroom	DC+
Legering Type	Martensitic steel weld metal

Typische lasmetaalanalyse (%)

C	Mn	Si	Cr	Mo
OK Flux 10.71				
0.15	1.14	0.51	4.07	0.77

Neersmeltgegevens

Diameter	Ampère	Volt	Draadaanvoersnelheid	Neersmelwaarde
3.0 mm	400-700 A	28-36 V	2.5-5.5 m/min	5.5-12.0 kg/h
4.0 mm	500-900 A	28-34 V	2.0-5.0 m/min	6.5-12.5 kg/h