

OK Weartrade 40

OK Weartrade 40 is used in applications exposed to metal to metal wear. A common application is surfacing wear resistant dies operating at temperatures up to 400°C. OK Weartrade 40 provides a weld metal with minimum hardness level of 40 HRC, typical value is around 45 HRC.

Specifications

Classifications	EN 14700 : E Z Fe2
Welding Current	DC+
Alloy Type	C, Mn , Si, Cr, V
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V
0.20	0.9	0.4	2.0	0.5	0.5

Deposition Data

Diameter	Current	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	90-130 A	71 %	97 sec	1.1 kg/h
4.0 x 450.0 mm	160-180 A	67 %	112 sec	1.4 kg/h
5.0 x 450.0 mm	170-220 A	71 %	127 sec	2.0 kg/h