

OK Wearode 50

General purpose hardfacing electrode for repair welding worn parts on agricultural equipment, forestry tools, loading machines, etc. Transformers with low low open circuit voltage can be used (>45 volt).

Specifications	
Classifications	EN 14700 : E Z Fe2

Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Acid Rutile

Typical Weld Metal Analysis %				
C	Mn	Si	Cr	Mo
0.46	0.4	0.5	6.0	0.5

Deposition Data					
Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350.0 mm	60-120 A	28 V	46 %	49 sec	0.8 kg/h
3.2 x 350.0 mm	90-160 A	30 V	46 %	59 sec	1.2 kg/h
4.0 x 450.0 mm	125-210 A	33 V	48 %	82 sec	1.7 kg/h
5.0 x 450.0 mm	160-260 A	37 V	48 %	86 sec	2.6 kg/h