



OK Tubrodur 200 O D

An 18-8-6 self-shielded cored wire for cladding and joining 13% Mn steels

Specifications

Classifications	EN 14700 : T Fe10
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Welding Current	DC+
Alloy Type	Austenitic Cr-Ni-Mn weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.026	5.12	0.48	8.7	19.1

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.6 mm (1/16 in.)	150-450 A	21-40 V	2.4-11.9 m/min (94-469 in./min)	1.8-9.0 kg/h (4.0-19. lbs/h)
2.4 mm (3/32 in.)	250-550 A	26-40 V	2.5-9.0 m/min (98-354 in./min)	3.7-11.4 kg/h (8.2-25.1 lbs/h)