

OK Tubrodur 40 O M

A self-shielded cored wire depositing a Cr-Ni-Mo alloyed weld metal.

Classifications	EN 14700 : T Z Fe2
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Welding Current	DC+
Alloy Type	Martensitic steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Al
No shielding gas						
0.14	1.59	0.62	0.55	4.64	0.49	1.55

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-300 A	25-36 V	5.0-12.6 m/min	2.4-6.8 kg/h