



## OK Tubrodur 40 S M

A tubular hardfacing wire for rebuilding and surfacing using the submerged arc welding process.

<b>Classifications</b>	EN 14700 : T Z Fe1
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<b>Welding Current</b>	DC+
<b>Alloy Type</b>	Martensitic steel weld metal

### Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
<b>OK Flux 10.71</b>				
0.15	1.14	0.51	4.07	0.77

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
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