

OK Wearrode 30



Electrode depositing a low alloy steel for the protection of parts exposed to metallic wear. Typical application include rail and rail crossing section, cog wheels of cast steel, detail in rolling mills, e.g. grooved rollers and clutches. Weld metal hardness approximately 30 HRC.

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|------------------------|---------------------------------|
| Classifications | EN 14700 : E Z Fe1 |
| Approvals | CE : EN 13479 DB : 82.039.07 |

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|------------------------|-------------------|
| Welding Current | AC, DC+ |
| Alloy Type | Martensitic steel |
| Coating Type | Lime Basic |

Typical Weld Metal Analysis %

| C | Mn | Si | Cr |
|-----|-----|-----|-----|
| 0.1 | 0.7 | 0.7 | 3.2 |

Deposition Data

| Diameter | Current | Voltage | Efficiency (%) | Number of electrodes/kg weld metal | Fusion time per electrode at 90% I max | Deposition Rate |
|----------------|-----------|---------|----------------|------------------------------------|--|-----------------|
| 2.5 x 350.0 mm | 60-90 A | 20 V | 64 % | 69 | 75 sec | 0.7 kg/h |
| 3.2 x 450.0 mm | 100-140 A | 21 V | 66 % | 34 | 88 sec | 1.2 kg/h |
| 4.0 x 450.0 mm | 140-190 A | 22 V | 66 % | 23 | 92 sec | 1.7 kg/h |
| 5.0 x 450.0 mm | 190-260 A | 23 V | 68 % | 15 | 86 sec | 2.8 kg/h |
| 6.0 x 450.0 mm | 230-320 A | 23 V | 68 % | 11 | 92 sec | 3.7 kg/h |