

OK Weartrode 55 HD



A general purpose hardfacing electrode depositing a semi corrosion resistant martensitic steel with a hardness of about 57 HRC. The electrode is specially suitable for hardfacing parts exposed to different forms of abrasive and impact wear, e.g. farming equipment, forestry tools, loading machines and mixers. Additional information is found under the heading "Other Data".

Classifications	EN 14700 : E Z Fe6
Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Lime Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.67	0.7	0.7	10.4

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 (0.098 x 13.8 in.)	75-110 A	23 V	67 %	58	62 sec	1.0 kg/h (2.2 lbs/h)
3.2 x 450.0 mm (1/8 x 17.7 in.)	110-150 A	23 V	67 %	27	95 sec	1.4 kg/h (3.1 lbs/h)
4.0 x 450.0 mm (5/32 x 17.7 in.)	145-200 A	24 V	67 %	18	107 sec	1.9 kg/h (4.2 lbs/h)
5.0 x 450.0 mm (0.197 x 17.7 in.)	190-270 A	26 V	66 %	12	110 sec	2.8 kg/h (6.2 lbs/h)