

OK Weartrode 60 T



Classifications	EN 14700 : E Z Fe14
Welding Current	AC, DC+
Alloy Type	Carbide rich steel
Coating Type	Rutile Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
4.8	1.0	0.7	34.3

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	90-120 A	24 V	62 %	48	60 sec	1.2 kg/h
3.2 x 350.0 mm	115-170 A	24 V	62 %	26	85 sec	1.6 kg/h
4.0 x 450.0 mm	130-210 A	26 V	64 %	14	135 sec	2.0 kg/h
5.0 x 450.0 mm	150-300 A	26 V	64 %	9	140 sec	2.9 kg/h