

OK Weartrode 62



A hardfacing electrode depositing a weld metal with a high volume fraction of fine carbides in a martensitic matrix. It is designed for protection of parts subjected to severe abrasion from rock, sand, cement, etc. Applications: Earth-drilling equipment. Hammers, scrapers, knives, conveyor screws, etc.

Welding Current	AC, DC+-
Alloy Type	Carbide rich steel
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr	V	Ti
2.9	0.4	1.9	6.2	5.2	4.9

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	70-100 A	17 V	63 %	71	105 sec	0.5 kg/h
3.2 x 350.0 mm	100-150 A	17 V	60 %	44	110 sec	0.7 kg/h
4.0 x 350.0 mm	115-200 A	17 V	64 %	27	120 sec	1.0 kg/h