OK Weartrode 65 T

The electrode deposits a high density of wear resisting carbides in an austenitic matrix capable of resisting extreme conditions of abrasion up to 700 °C. Recovery approximately 220 %. Typical applications include exhaust fans, ash ploughs, conveyor screws and sinter plant components.

Classifications	EN 14700 : E Fe16

Welding Current	DC+
Alloy Type	Austenitic iron
Coating Type	Special

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V	Nb	W
6.0	0.7	1.9	24.5	6.6	0.8	5.4	1.7

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 350.0 mm	150-170 A	22 V	72 %	22	132 sec	1.2 kg/h
4.0 x 350.0 mm	220-250 A	23 V	71 %	15	123 sec	2.0 kg/h

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