

## OK Weartrode 60



Electrode for hardfacing parts of dredgers, feed screws, crusher and tractor parts exposed to wear by stone, coal, sand, soil, etc. The weld metal presents a relatively good resistance to oxidation, also at elevated temperatures.

<b>Classifications</b>	EN 14700 : E Z Fe2
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<b>Welding Current</b>	AC, DC+
<b>Alloy Type</b>	Martensitic steel
<b>Coating Type</b>	Basic

### Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.80	0.4	4.5	2.0

### Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
3.2 x 450.0 mm	100-140 A	23 V	34	87 sec	68 %	1.2 kg/h
4.0 x 450.0 mm	140-190 A	25 V	22	90 sec	68 %	1.8 kg/h