

OK Weartrode 30



Electrode depositing a low alloy steel for the protection of parts exposed to metallic wear.

Typical application include rail and rail crossing section, cog wheels of cast steel, detail in rolling mills, e.g. grooved rollers and clutches.

Weld metal hardness approximately 30 HRC.

Classifications	EN 14700 : E Z Fe1
Approvals	CE EN 13479 DB 82.039.07

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Lime Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.1	0.7	0.7	3.2

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
2.5 x 350.0 mm	60-90 A	20 V	69	75 sec	64 %	0.7 kg/h
3.2 x 450.0 mm	100-140 A	21 V	34	88 sec	66 %	1.2 kg/h
4.0 x 450.0 mm	140-190 A	22 V	23	92 sec	66 %	1.7 kg/h
5.0 x 450.0 mm	190-260 A	23 V	15	86 sec	68 %	2.8 kg/h
6.0 x 450.0 mm	230-320 A	23 V	11	92 sec	68 %	3.7 kg/h