

OK Weartrode 60 T



Electrode giving a weld metal with coarse chromium carbides in an austenitic matrix. Suitable for surfacing worn parts in earth-moving equipment, sand pumps, mixers, feed screws, dust extractors, crushers etc exposed to wear by coal, ores and other minerals. Also in corrosive environment and/or elevated temperature.

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