OK Weartrode 55 HD



A general purpose hardfacing electrode depositing a semi corrosion resistant martensitic steel with a hardness of about 57 HRC. The electrode is specially suitable for hardfacing parts exposed to different forms of abrasive and impact wear, e.g. farming equipment, forestry tools, loading machines and mixers.

Specifications	
Classifications	EN 14700 : E Z Fe6

Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Lime Basic
Min AC OCV	65

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Cr**
0.67	0.7	0.7	10.4

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350 mm	75-110 A	23 V	67 %	62 sec	1.0 kg/h
3.2 x 450 mm	110-150 A	23 V	67 %	95 sec	1.4 kg/h
4.0 x 450 mm	145-200 A	24 V	67 %	107 sec	1.9 kg/h
5.0 x 450 mm	190-270 A	26 V	66 %	110 sec	2.8 kg/h