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.

Specifications	
Classifications	EN 14700 : E Z Fe14

Welding Current	AC, DC+
Alloy Type	Carbide rich steel
Coating Type	Rutile Basic
Min AC OCV	50

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Cr**
4.8	1.0	0.7	34.3

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 350 mm	90-120 A	24 V	62 %	60 sec	1.2 kg/h
3.2 x 350 mm	115-170 A	24 V	62 %	85 sec	1.6 kg/h
4.0 x 450 mm	130-210 A	26 V	64 %	135 sec	2.0 kg/h
5.0 x 450 mm	150-300 A	26 V	64 %	140 sec	2.9 kg/h