

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.

Specifications

Classifications EN 14700 : E Z Fe1

Approvals DB : 82.039.07

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

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.1	0.7	0.7	3.2

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 350 mm	60-90 A	20 V	64 %	75 sec	0.7 kg/h
3.2 x 450 mm	100-140 A	21 V	66 %	88 sec	1.2 kg/h
4.0 x 450 mm	140-190 A	22 V	66 %	92 sec	1.7 kg/h
5.0 x 450 mm	190-260 A	23 V	68 %	86 sec	2.8 kg/h
6.0 x 450 mm	230-320 A	23 V	68 %	92 sec	3.7 kg/h