

OK Tubrodur 15.50

FCAW

Type Metal-cored

MF6-55GP

Description

OK Tubrodur 15.50 deposits a weld metal with a structure consisting of evenly divided, hard chromium carbides in a martensitic matrix, with a hardness of HV 600-700.

It is suitable for hardfacing parts subjected to extremely severe service conditions involving a combination of impact and abrasion. The weld deposit can only be machined by grinding.

It is advisable to apply no more than three layers of weld metal. When badly worn surfaces have to be rebuilt, it is recommended to begin by using a tougher weld metal.

Applications

- Mill hammers
- Parts of agricultural equipment
- Earth-moving equipment
- Grinders for animal carcasses

Welding current

DC+

Classifications

DIN 8555 MF6-55GP

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.7	0.8	0.8	5.5	1.0

Typical mech. properties all weld metal

Weld metal hardness, a w 55-62 HRC

Deposition data at max. current

Diameter, mm	Welding current, A	Arc voltage, V
1.2	150-350	18-34
1.6	150-450	21-40
2.4	250-550	26-40