

OK Weartrode 45

Heavy coated general purpose hardfacing electrode for worn parts providing a hardness level of approximately 45 HRC.

Specifications

Classifications	EN 14700 : E Z Fe3
Welding Current	DC+
Alloy Type	Martensitic
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.3	2.0	0.8	1.3

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	100-130 A	24 V	63 %	35,3	94 sec	1.1 kg/h
4.0 x 450.0 mm	130-180 A	26 V	60 %	25	105 sec	1.4 kg/h
5.0 x 450.0 mm	180-220 A	25 V	64 %	15,4	124 sec	1.9 kg/h