

OK Wearode 60 T



Electrode producing a weld metal with coarse chromium carbides in an austenitic matrix. Suitable for surfacing worn parts exposed to abrasion and wear by coal, ore or other minerals. Typical applications include earth-moving machines, mixers, feeder screws, dust exhausters and crushers. It can also be used on components operating in corrosive environments and/or at elevated temperatures.

Classifications:	EN 14700:E Z Fe14
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Welding Current:	AC, DC+
Alloy Type:	Carbide rich steel
Coating Type:	Rutile Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
4.8	1.0	0.7	34.3

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	90-120 A	24 V	0.62	48	60 s	1.2 kg/h
3.2 x 350 mm	115-170 A	24 V	0.62	26	85 s	1.6 kg/h
4.0 x 450 mm	130-210 A	26 V	0.64	14	135 s	2.0 kg/h
5.0 x 450 mm	150-300 A	26 V	0.64	9	140 s	2.9 kg/h