Product Data Sheet — OK Tubrodur 55 O A

T 'Tubular cored electrode arc welding'

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
Neil Farrow	Tero Tolonen	Neil Farrow	EN006254	None	2013-10-31	1 (1)

REASON FOR ISSUE

Name changed from OK Tubrodur 14.70

GENERAL

A self-shielded Cr carbide cored wire.

Shielding Gas: None
Polarity: DC+

Alloy Type: Carbide-rich steel weld metal
Fill Type: Small amount of slag-forming elements

CLASSIFICATIONS Weld Metal

EN 14700 T Z Fe14

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	3.0	4.0
Si	0.3	0.6
Mn	0.6	1.2
P		0.03
S		0.03
Cr	19.0	23.0
Mo	3.0	4.0
V	0.3	0.6
Comments: Hv30 500 - 700		

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
Ø	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.6	200	400	na	85	2.5	8.0	3.2	10.5	30	36

W = Gas consumption (l / min)
η = Recovery, g weld metal / 100g wire (%)
H = Deposit rate (kg weld metal / hour arc time)
Feed = Feeding rate (m/min)
U = Arc voltage (V)