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.

Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Lime Basic
Min AC OCV	65

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Cr**
0.1	0.7	0.7	3.2

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
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