OK Weartrode 30 HD



High recovery electrode for cladding and hardfacing rails, rail points, crossings, wheel conveyors, rolls etc. Used in the same type of applications as OK Weartrode 30. Weld metal hardness approx. 30 HRC.

Specifications	
Classifications	EN 14700 : E Fe1

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

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Cr**
0.1	0.8	0.7	3.0

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
3.2 x 450 mm	110-180 A	26 V	67 %	66 sec	2.4 kg/h
4.0 x 450 mm	160-240 A	30 V	67 %	69 sec	3.4 kg/h
5.0 x 450 mm	230-330 A	42 V	68 %	73 sec	5.0 kg/h