# OK Weartrode 60 T




Electrode giving a weld metal with coarse chromium carbides in an austenitic matrix. Suitable for surfacing worn parts in earth-moving equipment, sand pumps, mixers, feed screws, dust extractors, crushers etc exposed to wear by coal, ores and other minerals. Also in corrosive environment and/or elevated temperature.

| Specifications | |
|---|---|
| **Classifications** | EN 14700 : E Z Fe14 |

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|---|---|
| **Welding Current** | AC, DC+ |
| **Alloy Type** | Carbide rich steel |
| **Coating Type** | Rutile Basic |
| **Min AC OCV** | 50 |

| Typical Weld Metal Analysis % | | | |
|---|---|---|---|
| **C** | **Mn** | **Si** | **Cr** |
| 4.8 | 1.0 | 0.7 | 34.3 |

| Deposition Data | | | | | |
|---|---|---|---|---|---|
| **Diameter** | **Amps** | **Volts** | **Efficiency (Per)** | **Fusion time per electrode at 90Per I max** | **Deposition rate at 90Per** |
| 2.5 x 350 mm | 90-120 A | 24 V | 62 % | 60 sec | 1.2 kg/h |
| 3.2 x 350 mm | 115-170 A | 24 V | 62 % | 85 sec | 1.6 kg/h |
| 4.0 x 450 mm | 130-210 A | 26 V | 64 % | 135 sec | 2.0 kg/h |
| 5.0 x 450 mm | 150-300 A | 26 V | 64 % | 140 sec | 2.9 kg/h |