OK Weartrode 62



A hardfacing electrode depositing a weld metal with a high volume fraction of fine carbides in a martensitic matrix. It is designed for protection of parts subjected to severe abrasion from rock, sand, cement, etc. Applications: Earth-drilling equipment. Hammers, scrapers, knives, conveyor screws,etc.

Welding Current	AC, DC+-
Alloy Type	Carbide rich steel
Coating Type	Basic
Min AC OCV	45

Typical Weld Metal Analysis %					
C	**Mn**	**Si**	**Cr**	**V**	**Ti**
2.9	0.4	1.9	6.2	5.2	4.9

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
3.2 x 350 mm	100-150 A	17 V	60 %	110 sec	0.7 kg/h
4.0 x 350 mm	115-200 A	17 V	64 %	120 sec	1.0 kg/h