

OK Weartrode 35



This electrode is a hardfacing basic type yielding an as welded hardness of 300 HV. It combats metal to metal wear and slight abrasion. It is used mainly for surfacing worn train and tramway rails. Also for carbon manganese crossings.

Other areas of use: Cog-wheels

Classifications	EN 14700 : E Fe1
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Welding Current	DC+
Ferrite Content	N/A
Alloy Type	C, Si, Mn, Cr
Coating Type	Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.09	0.9	0.8	3.0

Deposition Data

Diameter	Current	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
3.2 x 450.0 mm	110-140 A	36	84 sec	77 %	1.2 kg/h
4.0 x 450.0 mm	140-160 A	23	98 sec	77 %	1.6 kg/h
5.0 x 450.0 mm	180-200 A	15	100 sec	77 %	2.4 kg/h