

OK Weartrode 50



General purpose hardfacing electrode for repair welding worn parts on agricultural equipment, forestry tools, loading machines, etc. Transformers with low open circuit voltage can be used (>45 volt).

Specifications

Classifications	EN 14700 : E Z Fe2
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Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Acid Rutile
Min AC OCV	45

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.46	0.4	0.5	6.0	0.5

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350 mm	60-120 A	28 V	46 %	49 sec	0.8 kg/h
3.2 x 350 mm	90-160 A	30 V	46 %	59 sec	1.2 kg/h
4.0 x 450 mm	125-210 A	33 V	48 %	82 sec	1.7 kg/h
5.0 x 450 mm	160-260 A	37 V	48 %	86 sec	2.6 kg/h