

OK Weartrode 50



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

Klasifikácie	EN 14700 : E Z Fe2
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Zvárací prúd	AC, DC+
Typ zliatiny	Martensitic steel
Typ obalu	Acid Rutile

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.46	0.4	0.5	6.0	0.5

Naváracie údaje

Priemer	Prúd, A	V	Počet elektrod/zvarový kov	Doba odhorievania elektrody	Účinnosť %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	60-120 A	28 V	88	49 sec	46 %	0.8 kg/h
3.2 x 350.0 mm	90-160 A	30 V	52	59 sec	46 %	1.2 kg/h
4.0 x 450.0 mm	125-210 A	33 V	26	82 sec	48 %	1.7 kg/h
5.0 x 450.0 mm	160-260 A	37 V	16	86 sec	48 %	2.6 kg/h