

OK Autrodur 38 G M

OK Autrod 13.89 is a copper-coated, low-alloyed, solid GMAW wire used for hardfacing and building up, producing a wear-resistant weld metal with a hardness of between 35-40 HRC. It is used for the repair and maintenance of tracks, rails, wheels, rolls, rail crossings, shafts, shovel teeth and other parts on digging machines, tools like dies and so on.

Classifications Wire Electrode:	EN 14700:Fe2
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Alloy Type:	Low alloyed (0.7 C, 2 % Mn, 1 % Cr, 0.2 % Ti)
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Typical Wire Composition %

C	Mn	Si	Cr	Ti
0.69	1.92	0.49	1.00	0.2

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	80-280 A	18-28 V	2,7-14,7 m/min	1-5,4 kg/h
1.2 mm	120-350 A	20-33 V	2,7-12,4 m/min	1,5-6,6 kg/h

OK Autrodur 56 G M

OK Autrod 13.91 is a copper coated, low-alloyed solid GMAW wire used for hardfacing and building up highly wear-resistant layers on tools and machinery parts, driving rollers, digging tools and so on. The hardness of the weld metal becomes 50-60 HRC.

Classifications Wire Electrode:	EN 14700:Fe8
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Alloy Type:	Low alloyed (0.45 % C, 3 % Si, 9 % Cr)
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Typical Wire Composition %

C	Mn	Si	Cr
0.44	0.4	3.02	9.24

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm	80-280 A	18-28 V	2,7-14,7 m/min	1-5,4 kg/h
1.2 mm	120-350 A	20-33 V	2,7-12,4 m/min	1,5-6,6 kg/h
1.6 mm	225-480 A	26-38 V	3,1-8,1 m/min	3,3-0 kg/h