

OK Tubrodur 30 O M

OK Tubrodur 30 O M is a self-shielded, flux-cored wire for semi-automatic hardfacing, producing a chromium-manganese-alloyed weld metal with a hardness of 28-36 HRC. It is ideal for the on-site rebuilding of rollers, shafts, wheels and worn parts of CMn railway tracks, point frogs and so on.

Classifications Weld Metal:	EN 14700:T Z Fe1
Approvals:	CE EN 13479, DB 82.039.09

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Alloy Type:	Martensitic steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Al
0.10	1.41	0.43	2.94	1.37

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-300 A	25-36 V	5.0-12.6 m/min	2.4-6.8 kg/h
2.4 mm	250-550 A	26-40 V	2.5-9.0 m/min	3.7-11.4 kg/h

OK Tubrodur 35 G M

OK Tubrodur 35 G M is a CO₂-shielded, flux-cored wire for the hardfacing deposit of a manganese-chromium-molybdenum-alloyed weld metal. It is used for the surfacing of wheel runners, wheels and rollers for conveyor belts, wheels for mine trucks, rolls and shafts.

Classifications Weld Metal:	EN 14700:T Fe1
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Welding Current:	DC+
Alloy Type:	Martensitic steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Cr
C1 shielding gas			
0.21	1.40	1.10	1.47

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	250-350 A	28-34 V	5.0-12.6 m/min	2.4-6.8 kg/h