

OK Tubrodur 60 G M

OK Tubrodur 60 G M deposits a weld metal with a structure consisting of evenly divided, hard chromium carbides in a martensitic matrix, with a hardness of HV 600-700. It is suitable for hardfacing parts subjected to extremely severe service conditions involving a combination of impact and abrasion. The weld deposit can only be machined by grinding. It is advisable to apply no more than three layers of weld metal. When badly worn surfaces have to be rebuilt, it is recommended to begin by using a tougher weld metal.

Applications:

- Mill hammers
- Parts of agricultural equipment
- Earth-moving equipment
- Grinders for animal carcasses

Classifications Weld Metal:	DIN 8555:MF6-55GP, EN 14700:T Z Fe2
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Welding Current:	DC+
Alloy Type:	5%Cr 1%Mo

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.67	0.78	0.71	5.33	1.00

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	18-34 V	5.3-16.4 m/min	2.2-7.0 kg/h
1.6 mm	150-450 A	21-40 V	2.4-11.9 m/min	1.8-9.0 kg/h