

# OK Weartrode 30



OK Weartrode 30 is a chromium-alloyed electrode for hardfacing and cladding tracks, shafts, rolls, rails and rail-crossing sections, as well as components in rolling mills, such as grooved rollers and clutches and large cog wheels made of cast steel. The joining of hardenable steels is another application.

<b>Classifications:</b>	EN 14700:E Z Fe1
<b>Approvals:</b>	CE EN 13479, DB 82.039.07

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

<b>Welding Current:</b>	AC, DC+
<b>Alloy Type:</b>	Martensitic steel
<b>Coating Type:</b>	Lime Basic

## Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.1	0.7	0.7	3.2

## Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	60-90 A	20 V	0.64	69	75 s	0.7 kg/h
3.2 x 450 mm	100-140 A	21 V	0.66	34	88 s	1.2 kg/h
4.0 x 450 mm	140-190 A	22 V	0.66	23	92 s	1.7 kg/h
5.0 x 450 mm	190-260 A	23 V	0.68	15	86 s	2.8 kg/h
6.0 x 450 mm	230-320 A	23 V	0.68	11	92 s	3.7 kg/h