

OK Wearrode 35



This electrode is a hardfacing basic type yielding an as welded hardness of 300 HV. It combats metal to metal wear and slight abrasion. It is used mainly for surfacing worn train and tramway rails. Also for carbon manganese crossings.

Other areas of use: Cog-wheels.

| | |
|-------------------------|----------------|
| Classifications: | EN 14700:E Fe1 |
| Welding Current: | DC+ |
| Ferrite Content: | N/A |
| Alloy Type: | C, Si, Mn, Cr |
| Coating Type: | Basic |

Typical Weld Metal Analysis %

| C | Mn | Si | Cr |
|------|-----|-----|-----|
| 0.09 | 0.9 | 0.8 | 3.0 |

Deposition Data

| Diameter | Current | kg weld metal/kg electrodes | Number of electrodes/kg weld metal | Fusion time per electrode at 90% I max | Deposition rate 90% I max |
|--------------|-----------|-----------------------------|------------------------------------|--|---------------------------|
| 3.2 x 450 mm | 110-140 A | 0.77 | 36 | 84 s | 1.2 kg/h |
| 4.0 x 450 mm | 140-160 A | 0.77 | 23 | 98 s | 1.6 kg/h |
| 5.0 x 450 mm | 180-200 A | 0.77 | 15 | 100 s | 2.4 kg/h |