

# OK Weartrode 50



General purpose hardfacing electrode for repair welding worn parts on agricultural equipment, forestry tools, loading machines, etc. Transformers with low low open circuit voltage can be used (>45 volt).

<b>Classifications:</b>	EN 14700:E Z Fe2
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<b>Welding Current:</b>	AC, DC+
<b>Alloy Type:</b>	Martensitic steel
<b>Coating Type:</b>	Acid Rutile

## Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo
0.46	0.4	0.5	6.0	0.5

## 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	60-120 A	28 V	0.46	88	49 s	0.8 kg/h
3.2 x 350 mm	90-160 A	30 V	0.46	52	59 s	1.2 kg/h
4.0 x 450 mm	125-210 A	33 V	0.48	26	82 s	1.7 kg/h
5.0 x 450 mm	160-260 A	37 V	0.48	16	86 s	2.6 kg/h