



Product Data Sheet

S 'Submerged arc welding'

OK Tubrodur 58 S M

Prepared by Neil Farrow	Qualified by Tero Tolonen	Approved by Neil Farrow	Reg no EN006266	Cancelling None	Reg date 2013-10-31	Page 1 (1)
----------------------------	------------------------------	----------------------------	--------------------	--------------------	------------------------	---------------

REASON FOR ISSUE

Name changed from OK Tubrodur 15.52S

GENERAL

A tubular hardfacing wire for rebuilding and surfacing using the submerged arc welding process.

Welding Position: PA

Alloy Type: Martensitic steel weld metal

Polarity: DC+

Fill Type: Metal cored

CLASSIFICATIONS Weld Metal

EN 14700 T Fe6

CHEMICAL COMPOSITION

All Weld Metal (%)

OK Flux 10.71

	Min	Max
C	0.30	0.50
Si	0.4	0.8
Mn	1.3	1.8
P		0.05
S		0.03
Cr	4.0	6.0
Mo	0.8	1.6

Comments:
Hardness = 550 - 650 Hv

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
	Min	Max			Nom	Nom	Min	Max	Min	Max
\emptyset 3.0	400	700		90	5.5	12.0	2.5	5.5	28	36

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)