



Product Data Sheet

E 'Manual metal-arc welding'

OK Wearrode 30

Former OK 83.28

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by Tapio Huhtala	Reg no EN007049	Cancelling EN006238	Reg date 2016-02-12	Page 1 (2)
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REASON FOR ISSUE

Information under Other Data revised.

GENERAL

Electrode depositing a low alloy steel for the protection of parts exposed to metallic wear.

Typical application include rail and rail crossing section, cog wheels of cast steel, detail in rolling mills, e.g. grooved rollers and clutches.

Weld metal hardness approximately 30 HRC.

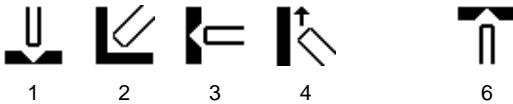
Min AC OCV: 65

Polarity: AC, DC+

Alloy Type: Martensitic steel

Coating Type: Lime Basic

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN 14700

E Z Fe1

APPROVALS

CE

EN 13479

DB

82.039.07

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.06	0.14
Si		0.7
Mn	0.4	1.0
P		0.03
S		0.03
Cr	2.5	3.9
Mo		0.1
W		0.1
V		0.1

ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	60	90	2.3	120	0.64	69	0.7	75	20	1,2,3,4,6
3.2 x 450	100	140	4.4	115	0.66	34	1.2	88	21	1,2,3,4,6
4.0 x 450	140	190	6.7	110	0.66	23	1.7	92	22	1,2,3,4,6
5.0 x 450	190	260	9.8	110	0.68	15	2.8	86	23	1,2,3
6.0 x 450	230	320	14.2	110	0.68	11	3.7	92	23	1,2,3

W = Weight (kg / 100 electrodes)

η = Efficiency (g weld metal x 100 / g core wire)

N = Effective value (kg weld metal / kg electrodes)

B = Changes (number of electrodes / kg weld metal)

H = Deposit rate at 90% of max current (kg weld metal / hour arc time)

T = Fusion time at 90% of max current (s / electrode)

U = Arc voltage (V)



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OTHER DATA

Weld metal hardness, typical:

- as welded : 30 HRC (no preheat, interpass temp. < 90 °C).

- after tempering:

Temp °C.....HRC (1h tempering)....HRC (24 h tempering)

100.....33.....33

300.....33.....33

400.....34.....34

500.....35.....28

600.....27.....17

700.....18

Machinability: Good

Impact resistance: Very good

Metal to metal wear resistance: Very good

Redrying the electrodes: 200 °C, 2 h.