



# Product Data Sheet

E 'Manual metal-arc welding'

# OK Weartrode 30 HD

Former OK 83.29

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by Tapio Huhtala	Reg no EN007048	Cancelling EN006237	Reg date 2016-02-12	Page 1 (2)
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## REASON FOR ISSUE

Description and information under Other Data revised.

## GENERAL

High recovery electrode for cladding and hardfacing rails, rail points, crossings, wheel conveyors, rolls etc. Used in the same type of applications as OK Weartrode 30.

Weld metal hardness approx. 30 HRC.

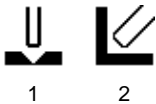
**Min AC OCV:** 65

**Alloy Type:** Martensitic steel

**Polarity:** AC, DC+

**Coating Type:** Zircon Basic

## WELDING POSITIONS



## CLASSIFICATIONS Electrode

EN 14700

E Fe1

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	0.06	0.14
Si	0.2	0.8
Mn	0.5	1.0
P		0.04
S		0.04
Cr	2.8	3.5
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								
3.2 x 450	110	180	6.5	170	0.67	23	2.4	66	26	1,2
4.0 x 450	160	240	9.9	165	0.67	15	3.4	69	30	1,2
5.0 x 450	230	330	14.6	165	0.68	10	5.0	73	42	1,2

**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

Hardness: as welded, approx. 30 HRC (no preheat, interpass temperature < 90 °C)

Temper resistance (1 h tempering):

Temp. °C.....HRC

100 ..... 34

300 ..... 34

500 ..... 33

600 ..... 20

700 ..... 17

Machinability: Good

Impact resistance: Very good

Metal to metal wear resistance: Very good

Redying the electrodes: 350 °C, 2 h.

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