



Product Data Sheet

E 'Manual metal-arc welding'

OK Weartrode 62

Former OK 84.84

Prepared by A-C Thorsson	Qualified by Tero Borg	Approved by Tapio Huhtala	Reg no EN007058	Cancelling EN006243	Reg date 2016-02-15	Page 1 (2)
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REASON FOR ISSUE

Information under Other Data revised.

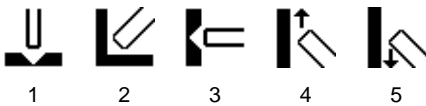
GENERAL

A hardfacing electrode depositing a weld metal with a high volume fraction of fine carbides in a martensitic matrix. It is designed for protection of parts subjected to severe abrasion from rock, sand, cement, etc. Applications: Earth-drilling equipment. Hammers, scrapers, knives, conveyor screws, etc.

Min AC OCV: 45
Polarity: AC, DC+-

Alloy Type: Carbide rich steel
Coating Type: Basic

WELDING POSITIONS



CLASSIFICATIONS weld metal

Not applicable

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	2.5	3.5
Si	1.5	2.5
Mn		0.5
P		0.020
S		0.010
Cr	5.5	7.0
V	4.5	5.5
Ti	4.0	5.5

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	70	100	2.3	115	0.63	71	0.5	105	17	1,2,3,4,5
3.2 x 350	100	150	3.8	115	0.60	44	0.7	110	17	1,2,3,4,5
4.0 x 350	115	200	5.9	125	0.64	27	1.0	120	17	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)

OTHER DATA

Welding: Preheating is normally not required. For heavier sections a raised temperature up to 200 °C may be



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OTHER DATA

beneficial. Stringer beads recommended. Use medium arc length. Keep electrode perpendicular to work piece. Optimum hardness is obtained already in the first layer due to low dilution of underlaying material.

Typical hardness, HRC (As welded on mild steel, no preheat.)

1 layer62

2 layers62

Machinability: Grinding only

Impact resistance: Very good

Abrasion resistance: Excellent

Redrying: 200 °C, 2h.
