# Product Data Sheet

E 'Manual metal-arc welding'

# OK Weartrode 62

Former OK 84.84

| Prepared by | Qualified by | Approved by | Reg no | Cancelling | Reg date | Page |
|---|---|---|---|---|---|---|
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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

1 2 3 4 5

## 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) | Current (A) | | W | η | N | B | H | T | U | Welding |
|---|---|---|---|---|---|---|---|---|---|---|
| Ø x Length | Min | Max | | | | | | | | Positions |
| 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

**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 layer .....62
2 layers .....62

Machinability: Grinding only
Impact resistance: Very good
Abrasion resistance: Excellent

Redrying: 200 °C, 2h.