



Product Data Sheet

E 'Manual metal-arc welding'

OK Wearrode 60

Formerly OK 83.65

Prepared by A-C Thorsson	Qualified by Tero Tolonen	Approved by Tapio Huhtala	Reg no EN006241	Cancelling None	Reg date 2013-10-29	Page 1 (2)
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REASON FOR ISSUE

New product. Changed name from OK 83.65.

GENERAL

Electrode for hardfacing parts of dredgers, feed screws, crusher and tractor parts exposed to wear by stone, coal, sand, soil, etc. The weld metal presents a relatively good resistance to oxidation, also at elevated temperatures.

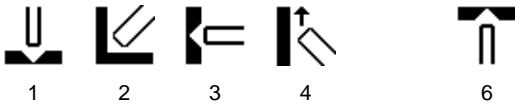
Min AC OCV: 65

Polarity: AC, DC+

Alloy Type: Martensitic steel

Coating Type: Basic

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN 14700

E Z Fe2

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.6	0.9
Si	3.4	4.6
Mn		0.6
P		0.03
S		0.03
Cr	1.5	2.5
Ni		0.3
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	100	140	4.3	115	0.68	34	1.2	87	23	1,2,3,4,6
4.0 x 450	140	190	6.6	115	0.68	22	1.8	90	25	1,2,3,4,6

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, typical as welded:

- 58-63 HRC top layer of a three-layer bead (without preheat, interpass temp. 60 °C).
- 56-60 HRC top layer of a three-layer bead (preheat and interpass temp. 300 °C).
- about 40 HRC small parts becoming red hot during welding.

Tempering resistance (1 hour tempering):

Temp. °C.....HRC

100	61
200	60
300	59
400	56
500	58
600	55
700	41

Redrying: 200 °C, 2 h.
