

## OK Weartrode 55 HD



A general purpose hardfacing electrode depositing a semi corrosion resistant martensitic steel with a hardness of about 57 HRC. The electrode is specially suitable for hardfacing parts exposed to different forms of abrasive and impact wear, e.g. farming equipment, forestry tools, loading machines and mixers.

Klasifikace	EN 14700: E Z Fe6
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Svařovací proud	AC, DC+
Typ legování	Martensitic steel
Typ obalu	Lime Basic

### Typical Wire Composition %

<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>
0.67	0.7	0.7	10.4

### Údaje ukládání

Průměr	A	V	Svarový kov/hmotnost elektrody	Počet elektrod/svarový kov	Čas dohoření/elektroda	Produktivita
2.5 x 350 mm	75-110 A	23 V	0.67	58	62 sec	1.0 kg/h
3.2 x 450 mm	110-150 A	23 V	0.67	27	95 sec	1.4 kg/h
4.0 x 450 mm	145-200 A	24 V	0.67	18	107 sec	1.9 kg/h
5.0 x 450 mm	190-270 A	26 V	0.66	12	110 sec	2.8 kg/h