



Product Data Sheet

E 'Manual metal-arc welding'

OK Weartrode 60 T

Formerly OK 84.78

Prepared by A-C Thorsson	Qualified by Tero Tolonen	Approved by Tapio Huhtala	Reg no EN006242	Cancelling None	Reg date 2013-10-29	Page 1 (2)
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REASON FOR ISSUE

New product. Changed name from OK 84.78.

GENERAL

Electrode giving a weld metal with coarse chromium carbides in an austenitic matrix. Suitable for surfacing worn parts in earth-moving equipment, sand pumps, mixers, feed screws, dust extractors, crushers etc exposed to wear by coal, ores and other minerals. Also in corrosive environment and/or elevated temperature.

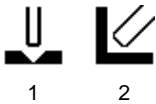
Min AC OCV: 50

Polarity: AC, DC+

Alloy Type: Carbide rich steel

Coating Type: Rutile Basic

WELDING POSITIONS



CLASSIFICATIONS Electrode

EN 14700

E Z Fe14

APPROVALS

Not applicable

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	3.5	5.5
Si	0.50	1.10
Mn		1.6
P		0.04
S		0.03
Cr	29.5	36.5
Ni		0.1
Mo		0.1

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	90	120	3.4	180	0.62	48	1.2	60	24	1,2
3.2 x 350	115	170	6.3	190	0.62	26	1.6	85	24	1,2
4.0 x 450	130	210	11.4	180	0.64	14	2.0	135	26	1,2
5.0 x 450	150	300	17.8	185	0.64	9	2.9	140	26	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, typical as welded:

3-layer 59-63 HRC (no preheat and interpass temp. 100 °C).

3-layer 55-61 HRC (preheat and interpass temp. ca 500 °C).

Tempering resistance:

Hardness at room temperature after 1 hour tempering in the range 100-700 °C, 3-layer weld. Diameter 4 mm electrode.

°C.....HRC

10058

30059

40057

49059

60057

70058

Redrying: 300 °C for 2 h.
