OK Tubrodur 53 G M

A cored wire which produces a Cr-Mo-V-Co-W alloyed weld metal for hardfacing used with C1 shielding gas.

Classifications Weld Metal:	EN 14700:T Fe3, DIN 8555:MF3-50T

Welding Current:	DC+
Alloy Type:	Surfacing alloy Cr-Mo-V-Co-W

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V	Co	W
C1 shielding gas							
0.33	1.14	0.94	1.76	0.44	0.40	2.03	8.17

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-450 A	21-40 V	2.4-11.9 m/min	1.8-9.0 kg/h

OK Tubrodur 55 O A

OK Tubrodur 55 O A is a self-shielded, Cr-carbide type flux-cored wire. The weld metal is extremely resistant to abrasive wear by gritty fine grain materials such as earth, ore, clay, etc. Typical applications are the hardfacing of bucket lips, auger points, mining and earthmoving equipment, scraper blades etc. Maximum 2-3 layers should be deposited.

Classifications Weld Metal:	EN 14700:T Z Fe14

Welding Current:	DC+
Alloy Type:	Carbide-rich steel weld metal

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V
3.6	0.88	0.53	22.5	3.5	0.5

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.6 mm	150-300 A	25-36 V	5.0-12.6 m/min	2.4-6.8 kg/h