OK Tooltrode 60

Hardfacing electrode of the high-speed steel for repair welding of cutting tools, drills, stamping machines etc. The weld metal obtains its maximum hardness by double tempering. Suitable for step welding.
To avoid issues with cracking, the working temperature should be preferrably 400-500°C.

Klasifikácie	EN 14700 : E Fe4

Zvárací prúd	AC, DC+
Typ zliatiny	Tool steel
Typ obalu	Lime Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V	W
0.93	1.4	1.4	4.7	7.3	1.60	1.39

Navárací údaje

Priemer	Prúd, A	V	Počet elektród/zvarový kov	Doba odhorievania elektródy	Účinnosť %	Deposition Rate @ 90% I max
2.5 x 350.0 mm	80-110 A	23 V	67	67 sec	55 %	0.8 kg/h
3.2 x 350.0 mm	100-150 A	23 V	40	82 sec	57 %	1.1 kg/h
4.0 x 350.0 mm	120-190 A	25 V	27	97 sec	58 %	1.4 kg/h

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