

OK 83.30



OK 83.30 is a rutile electrode for hardfacing and cladding tracks, shafts, rolls, rails, rail frogs etc when hardness of 30-35 HRC is required from the weld metal.

Classifications	EN 14700 : E Z Fe1
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Welding Current	AC, DC+
Alloy Type	Martensitic steel
Coating Type	Acid Rutile

Typical Weld Metal Analysis %

C	Mn	Si	Cr
0.1	1.1	0.7	3.3

Deposition Data

Diameter	Current	Voltage	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Efficiency %	Deposition Rate @ 90% I max
3.2 x 350.0 mm	90-180 A	26 V	55	50 sec	53 %	1.5 kg/h
4.0 x 450.0 mm	140-240 A	26 V	26	65 sec	57 %	2.2 kg/h
5.0 x 450.0 mm	160-310 A	27 V	17	85 sec	57 %	2.7 kg/h