

OK 83.28

Type Lime-basic

SMAW

E1-UM-300

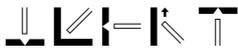
Description

OK 83.28 is a chromium-alloyed electrode for hardfacing and cladding tracks, shafts, rolls, rails and rail-crossing sections, as well as components in rolling mills, such as grooved rollers and clutches and large cog wheels made of cast steel.

The joining of hardenable steels is another application.

Welding current

AC, DC+ OCV 70 V



Classifications

DIN 8555 E1-UM-300

Typical all weld metal composition, %

C	Si	Mn	Cr
0.1	<0.7	0.7	3.2

Typical mech. properties all weld metal

Weld metal hardness, a w (no preheat, interpass temperature <90°C) ≈30 HRC
Machinability Good
Impact resistance Very good
Metal-to-metal wear resistance Very good

Tempering resistance

Temp°C	HRC(1h)	HRC(24h)
100	33	33
300	33	33
400	34	34
500	35	28
600	27	17
700	18	

Approvals

DB 20.039.01
Sepros UNA 485155
UDT DIN 8555

Deposition data at max current

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	60-90	20	0.64	69.0	0.7	75
3.2	450	100-140	21	0.66	34.0	1.2	88
4.0	450	140-190	22	0.66	23.0	1.7	92
5.0	450	190-260	23	0.68	15.0	2.8	86
6.0	450	230-320	23	0.68	10.5	3.7	92