

OK 86.08

Type Lime-basic

SMAW

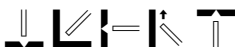
E7-UM-200-K

Description

OK 86.08 deposits an austenitic-manganese steel alloy which work-hardens under impact and compressive stresses. The electrode is primarily used for surfacing and building up manganese steel components such as crusher jaws and hammers. The interpass temperature should be kept as low as possible.

Welding current

AC, DC+ OCV 70 V



Classifications

DIN 8555 E7-UM-200-K

Typical all weld metal composition, %

C	Si	Mn
1.1	0.8	13.0

Typical mech. properties all weld metal

Weld metal hardness, a w (No preheat, interpass temperature 100-150°C)	180-200 HB
Weld metal hardness, w h (approx. 25% reduction)	44-48 HRC
Machinability	Grinding
Impact resistance	Excellent
Metal-to-metal wear resistance	Very good

Deposition data at max current

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of elec- trodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
3.2	450	95-135	23	0.60	35.5	1.1	95
4.0	450	130-180	23	0.60	24.0	1.4	109
5.0	450	170-230	25	0.60	15.0	1.8	132