

# OK 84.58

Type Lime-basic

SMAW

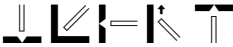
E6-UM-55-G

## Description

OK 84.58 is a hardfacing electrode depositing a semi-corrosion-resistant martensitic steel. Full hardness is obtained even in the first bead, irrespective of the cooling rate. Suitable for hardfacing parts exposed to abrasive and impact wear, such as farm equipment, forestry tools, loading machines and mixers.

## Welding current

AC, DC+ OCV 65 V



## Classifications

DIN 8555 E6-UM-55-G

## Typical all weld metal composition, %

C	Si	Mn	Cr
0.7	0.6	0.7	10.0

## Typical mech. properties all weld metal

Weld metal hardness, a w deposited on mild steel, no preheat, interpass temperature 250°C)	53-59 HRC
1st layer	52-59 HRC
2nd layer	52-59 HRC
3rd layer	53-59 HRC
Machinability	Grinding only
Abrasion resistance	Very good
High temp. wear resistance	Good
Corrosion resistance	Good

## Tempering resistance

Temp°C/1h	HRC
100	55
200	55
300	52
400	50
500	54
600	46
700	31

## Annealing and hardening of weld metal:

Soft annealing: 840-860°C

Rehardening procedure:

Hardening temperature, °C: 950- 1000

Quenching medium: compressed air or oil

## 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	75-110	23	0.67	58.0	1.0	62
3.2	450	110-150	23	0.67	27.0	1.4	95
4.0	450	145-200	24	0.67	17.5	1.9	107
5.0	450	190-270	26	0.66	11.5	2.8	110
6.0	450	250-370	28	0.65	8.5	4.0	110