



# Product Data Sheet

E 'Manual metal-arc welding'

# OK Weartrode 62

Formerly OK 84.84

Prepared by A-C Thorsson	Qualified by Tero Tolonen	Approved by Tapio Huhtala	Reg no EN006243	Cancelling None	Reg date 2013-10-29	Page 1 (2)
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## REASON FOR ISSUE

New product. Changed name from OK 84.84.

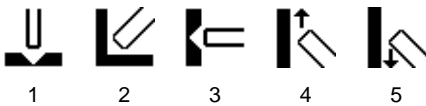
## GENERAL

A hardfacing electrode depositing a weld metal with a high volume fraction of fine carbides in a martensitic matrix. It is designed for protection of parts subjected to severe abrasion from rock, sand, cement, etc. Applications: Earth-drilling equipment. Hammers, scrapers, knives, conveyor screws, etc.

**Min AC OCV:** 45  
**Polarity:** AC, DC+-

**Alloy Type:** Carbide rich steel  
**Coating Type:** Basic

## WELDING POSITIONS



## CLASSIFICATIONS weld metal

Not applicable

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	Min	Max
C	2.5	3.5
Si	1.5	2.5
Mn		0.5
P		0.020
S		0.010
Cr	5.5	7.0
V	4.5	5.5
Ti	4.0	5.5

## ECONOMICS & CURRENT DATA

Dimension (mm) Ø x Length	Current (A)		W	η	N	B	H	T	U	Welding Positions
	Min	Max								
2.5 x 350	70	100	2.3	115	0.63	71	0.5	105	17	1,2,3,4,5
3.2 x 350	100	150	3.8	115	0.60	44	0.7	110	17	1,2,3,4,5
4.0 x 350	115	200	5.9	125	0.64	27	1.0	120	17	1,2

- W** = Weight (kg / 100 electrodes)  
**η** = Efficiency (g weld metal x 100 / g core wire)  
**N** = Effective value (kg weld metal / kg electrodes)  
**B** = Changes (number of electrodes / kg weld metal)  
**H** = Deposit rate at 90% of max current (kg weld metal / hour arc time)  
**T** = Fusion time at 90% of max current (s / electrode)  
**U** = Arc voltage (V)

## OTHER DATA

Welding: Preheating is normally not required. For heavier sections a raised temperature up to 200 °C may be



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## OTHER DATA

beneficial. Stringer beads recommended. Use medium arc length. Keep electrode perpendicular to work piece. Optimum hardness is obtained already in the first layer due to low dilution of underlaying material.

Typical hardness, HRC (As welded on mild steel, no preheat.)

1 layer .....62

2 layers .....62

Machinability: Grinding only.

Redrying: 200 °C, 2h.

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