

OK Tubrodur 15.42

FCAW

Type Basic

Description

OK Tubrodur 15.42 is a self- or CO₂-shielded, flux-cored wire for GMAW hardfacing. It is designed for surfacing wheel runners, track links, billet rolls, wheels and rollers for conveyor belts, wheels for mine trucks, rolls and shafts, where a hardness of 35-45 HRC is desired.

Welding current

DC+



Classifications

no applicable classification

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Al
0.14	0.6	1.6	0.5	0.6	3.4	1.5

Typical mech. properties all weld metal

Weld metal hardness, a w	35-45 HRC
Machinability	Fair
Impact resistance	Good
Metal-to-metal wear resistance	Good
Abrasion resistance	Good

Deposition data at max. current

Diameter, mm	Welding current, A	Arc voltage, V
1.6	150-300	25-36