

OK Tubrodur 15.43 FCAW

Type Basic

Description

OK Tubrodur 15.43 is a self-shielded, flux-cored, tubular wire, primarily developed for the on-site rebuilding of worn CMn railway and tram tracks. The weld deposit is of the CrNiMo type and has excellent compressive strength with a hardness of 30-40 HRC.

Welding current

DC+



Classifications

no applicable classification

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Al
0.14	0.3	1.1	1.0	2.2	0.5	1.5

Typical mech. properties all weld metal

Weld metal hardness, a w	30-40 HRC
Machinability	Good
Impact resistance	Good
Metal-to-metal wear resistance	Very good

Deposition data at max. current

Diameter, mm	Welding current, A	Arc voltage, V
1.2	150-250	28-37
1.6	150-300	25-36