

OK Tubrodur 15.40S SAW

Type Metal cored

Description

OK Tubrodur 15.40S is a flux-cored wire for SAW hardfacing in conjunction with OK Flux 10.71, depositing a manganese-chromium-molybdenum-alloyed weld metal with a hardness of 32-36 Rockwell C. Suitable for surfacing wheel runners, track links, wheels and rollers for conveyor belts, wheels for mine trucks, rolls and shafts, where a hardness within the range of 32-40 Rockwell C is desired. With negative polarity, less heat input to the base material, less dilution of the weld metal and a higher deposition rate are obtained. In most cases, surfacing with OK Tubrodur 15.40S can be performed without preheat. The need for preheat and increased interpass temperature is determined by the weldability of the parent material in question and the form and dimensions of the workpiece. Whenever possible, surfaced axles and similar objects, which are exposed to a bending stress during rotation, should always be stress relieved at 500-600°C.

Welding current

DC+



Classifications

no applicable classification

Typical all weld metal composition, %

C	Si	Mn	Cr
0.11	0.7	1.4	2.9

Typical mech. properties all weld metal

Weld metal hardness, a w	32-40 HRC
Machinability	Good
Impact resistance	Good
Metal-to-metal wear resistance	Very good

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
2.4	250-450	28-38
3.0	400-700	28-36
4.0	500-900	28-34