OK 84.84

SMAW

Type Basic E10-UM-60-GP

Description

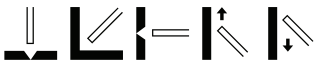
OK 84.84 is a hardfacing electrode depositing a weld metal with a high volume fraction of fine carbides in a martensitic matrix. It is designed for theprotection of components subjected to severe abrasive wear. Typical applications: earth-drilling equipment, hammers, scrapers and knives, shovel buckets and shovel teeth.

Recommendation:

Preheating is normally not required, except for heavier sections where preheating to 200°C may be beneficial. Stringer beads are recommended. Optimum hardness is obtained in the first layer due to low dilution with the parent material.

Welding current

AC, DC+ - OCV 45 V



Classifications

DIN 8555 E10-UM-60-GP

Typical all weld metal composition, %

C	Si	Cr	V	Ti
3.0	2.0	6.3	5.0	4.8

Typical mech. properties all weld metal

Weld metal hardness, a w (deposited on mild steel, no preheat):	60-62 HRC
1st layer:	62 HRC
Machinability	Grinding only
Impact resistance	Very good
Abrasion resistance	Excellent

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	70-100	17	0.63	71	0.5	105
3.2	350	100-150	17	0.60	44	0.7	110
4.0	350	115-200	17	0.64	27	1.0	120