

OK 86.28

Type Zirconium-basic

SMAW
EFeMn-A

Description

OK 86.28 is a high-recovery, austenitic-manganese steel electrode containing nickel. It produces a crack-resistant weld metal, which work-hardens under compressive stresses.

It is intended for surfacing and building up Mn-steel components exposed to severe impact and moderate abrasion. Typical applications include crusher plates and rolls, bulldozer teeth, cones and mantles of rotary crushers, dredger buckets, rail crossings and so on.

The interpass temperature should be kept as low as possible.

Welding current

AC, DC+ OCV 70 V



Classifications

SFA/AWS A5.13 EFeMn-A

Typical all weld metal composition, %

C	Si	Mn	Ni
0.8	<0.3	14.0	3.5

Typical mech. properties all weld metal

Weld metal hardness, a w (no preheat, interpass temperature 100- 150°C)	160-180 HB
Weld metal hardness, w h (approx. 25% reduction)	42-46 HRC
Machinability (overheating must be avoided)	Grinding
Impact resistance	Excellent

Approvals

DB	20.039.05
Sepros	UNA 409820

Deposition data at max current

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of elec- trodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
3.2	450	100-160	30	0.54	26.5	1.5	90
4.0	450	130-210	30	0.54	17.5	2.0	105
5.0	450	170-300	31	0.56	11.0	2.9	114