

OK Tooltrode 60



Hardfacing electrode of the high-speed steel for repair welding of cutting tools, drills, stamping machines etc. The weld metal obtains its maximum hardness by double tempering. Suitable for step welding. To avoid issues with cracking, the working temperature should be preferably 400-500°C.

Classifications:	EN 14700:E Fe4
Welding Current:	AC, DC+
Alloy Type:	Tool steel
Coating Type:	Lime Basic

Typical Weld Metal Analysis %

C	Mn	Si	Cr	Mo	V	W
0.93	1.4	1.4	4.7	7.3	1.60	1.39

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 350 mm	80-110 A	23 V	0.55	67	67 s	0.8 kg/h
3.2 x 350 mm	100-150 A	23 V	0.57	40	82 s	1.1 kg/h
4.0 x 350 mm	120-190 A	25 V	0.58	27	97 s	1.4 kg/h