

OK Autrodur 38 G M

A copper coated, low-alloyed solid GMAW wire used for hard facing and building up, giving a wear resistant weld metal with a hardness between 35-40 HRC. Used for repair and maintenance of e.g. tracks, rails, wheels, rolls, railcrossings, shafts, shovel teeth and other parts on digging machines, tools like dies etc.

Specifications	
Classifications	EN 14700 : Fe2
Approvals	NAKS/HAKC : 1.2MM

Alloy Type	Low alloyed (0.7 C, 2 % Mn, 1 % Cr, 0.2 % Ti)
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Typical Weld Metal Analysis %						
C	Mn	Si	S	P	Cr	Ti
Shielding gas;CO2						
0.6	1.0	0.2	0.01	0.01	1.0	0.05
Shielding gas;80Ar/20CO2						
0.6	1.4	0.4	0.01	0.01	1.0	0.06

Typical Wire Composition %				
C	Mn	Si	Cr	Ti
0.69	1.92	0.49	1.00	0.2

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.0 mm (0.040 in.)	80-280 A	18-28 V	2.7-14.7 m/min (106-579 in./min)	1.0-5.4 kg/h (2.2-11. lbs/h)
1.2 mm (0.047 in.)	120-350 A	20-33 V	2.7-12.4 m/min (106-488 in./min)	1.5-6.6 kg/h (3.3-14. lbs/h)