

OK Tubrodur 15.40 FCAW

Type Rutile

Description

OK Tubrodur 15.40 is a CO₂-shielded, flux-cored wire for the hardfacing deposit of a manganese-chromium-molybdenum-alloyed weld metal. It is used for the surfacing of wheel runners, wheels and rollers for conveyor belts, wheels for mine trucks, rolls and shafts.

Welding current

DC+



Classifications

no applicable classification

Typical all weld metal composition, %

C	Si	Mn	Cr
0.2	1.0	1.4	1.4

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
1.6

Welding current, A
250-350

Arc voltage, V
28-34