

# OK Tubrodur 15.65

FCAW

Type Rutile

## Description

OK Tubrodur 15.65 is a flux-cored wire for self- or CO<sub>2</sub> shielding, depositing a martensitic-austenitic, work-hardening deposit. OK Tubrodur 15.65 can be used for the rebuilding of mild, low-alloy and 13Mn steels. The weld metal combines excellent abrasion and impact resistance and is suitable for applications such as crusher jaws and hammers, railway point frogs, ripper teeth and wear plates.

## Welding current

DC+

## Classifications

no applicable classification

## Typical all weld metal composition, %

| C   | Si  | Mn   | Cr   | Ni  | Mo  |
|-----|-----|------|------|-----|-----|
| 0.3 | 0.6 | 13.5 | 15.5 | 1.8 | 0.8 |

## Typical mech. properties all weld metal

|                                |            |
|--------------------------------|------------|
| Weld metal hardness, a w       | 200-250 HV |
| Weld metal hardness, w h       | 400-500 HV |
| Machinability                  | Grinding   |
| Impact resistance              | Excellent  |
| Metal-to-metal wear resistance | Good       |

## Deposition data at max. current

| Diameter, mm | Welding current, A | Arc voltage, V |
|--------------|--------------------|----------------|
| 1.6          | 200-260            | 24-28          |
| 2.4          | 250-450            | 28-38          |