

OK 83.50

Type Acid-Rutile

SMAW

E6-UM-55

Description

OK 83.50 is a hardfacing electrode for the repair welding of worn parts on agricultural equipment, forestry tools, loading machines and so on. Transformers with low open-circuit voltage can be used (> 45 volt).

Welding current

AC, DC+ OCV 45 V



Classifications

DIN 8555 E6-UM-55

Typical all weld metal composition, %

C	Si	Mn	Cr	Mo
0.4	<0.6	<1.0	6.0	0.6

Typical mech. properties all weld metal

Weld metal hardness, a w (preheat and interpass temperature approx. 250°C)	50-60 HRC
Machinability	Grinding only
Abrasion resistance	Very good

Tempering resistance

Temp°C/1h	HRC
200	56
300	54
400	53
500	52
550	51
600	44
650	41
700	34

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
2.5	350	60-120	28	0.46	88.0	0.8	49
3.2	350	90-160	30	0.46	52.0	1.2	59
4.0	450	125-210	33	0.48	25.5	1.7	82
5.0	450	160-260	37	0.48	16.0	2.6	86