

OK 83.65

Type Basic

SMAW

E2-UM-60

Description

OK 83.65 deposits a hard, wear-resistant weld metal. Good resistance to oxidation up to about 875°C. Suitable for hardfacing machine parts exposed to wear from stone, coal, sand and soil. Typical applications are dredging machines, feeder screws, crusher and tractor parts.

Welding current

AC, DC+ OCV 70 V



Classifications

DIN 8555 E2-UM-60

Typical all weld metal composition, %

C	Si	Mn	Cr
0.8	4.0	<0.6	2.0

Typical mech. properties all weld metal

Weld metal hardness, a w
No preheat, interpass temperature 60°C: 58-63 HRC
Preheat and interpass temperature 300°C: 56-60 HRC
Machinability Grinding only
Abrasion resistance Very good

Tempering resistance

Temp°C/1h	HRC
100	61
200	60
300	59
400	56
500	58
600	55
700	41

Deposition data at max current

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
3.2	450	100-140	23	0.68	34	1.2	87
4.0	450	140-190	25	0.68	22	1.8	90