



# *Joining Rail with Stick Electrodes*



Joining Railsteel the ESAB way is the most economical besides being the stronger weld compared to alumino thermic welding



# *Mould Welding Kit*

*For the joining of rail*

**OK 21-21 OK 74-78 and OK 83-28**

The kit comprises of the following products:

**OK 21-21** a backing which is fixed under the joint opening when welding the foot of the rail.

**OK 74-78** a high strength electrode used for welding the foot and the web of the rail. Ø 5.0 mm

**OK 83-28** a hardfacing electrode having an as welded hardness of about 30 HRC for capping the rail surface. Ø 5.0 mm



**Each kit contains:**  
**OK Backing 21-21**  
2 pieces

**OK 74-78**  
30 electrodes

**OK 83-28**  
6 electrodes

# Item numbers for the kit and for separate items

**Kit Complete 2121747800**

**Part numbers for separate items**

**OK Backing 21-21 2121010000 60 x 210 x 13 mm**

**OK 74-78 74785040G0 Ø 5 mm and 450 mm long  
VacPac ½ pack**

**OK 83-28 83285040G0 Ø 5 mm and 450 mm long  
VacPac ½ pack**



**OK Backing 21-21 inserted**



**Foot welded with OK 74-78**



**Moulds applied**



**Welding the web of the rail**



**Hardfacing of top layer  
completed with  
OK 83-28**

Deflection not less than 14 mm at 800 MPa when joined with stick electrodes.

Alumino-thermic welding 12 mm at 800 MPa

