



Product Data Sheet

OK Tubrodur 35 S M

T 'Tubular cored electrode arc welding'

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REASON FOR ISSUE

Name changed from OK Tubrodur 15.40S

GENERAL

A hardfacing cored wire for rebuilding and surfacing with C1 shielding gas.

Shielding Gas: C1 (EN ISO 14175)

Alloy Type: Martensitic steel weld metal

Welding Position: PA

Fill Type: Rutile

Polarity: DC+

CLASSIFICATIONS Weld Metal

EN 14700

T Fe1

CHEMICAL COMPOSITION

All Weld Metal (%)

	OK Flux 10.37		OK Flux 10.71	
	Min	Max	Min	Max
C	0.07	0.20	0.07	0.25
Si		1.0		1.0
Mn	1.0	2.0	1.0	2.0
P		0.04		0.04
S		0.04		0.04
Cr	3.0	4.0	3.0	4.0
Ni				0.1
Mo				0.1
V				0.1
Nb				0.1

Comments:
Hardness = 310 - 400 Hv

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed			U
	Min	Max			Nom	Min	Max	Min	Max	
\emptyset			Nom	Nom	Min	Max	Min	Max	Min	Max
4.0	500	900		90	6.5	12.5	2.0	5.0	28	34

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)