

## OK 84.78

Electrode giving a weld metal with coarse chromium carbides in an austenitic matrix. Suitable for surfacing worn parts in earth-moving equipment, sand pumps, mixers, feed screws, dust extractors, crushers etc exposed to wear by coal, ores and other minerals. Also in corrosive environment and/or elevated temperature.

Specifications	
Classifications	EN 14700 : E Z Fe14

Welding Current	AC, DC+
Alloy Type	Carbide rich steel
Coating Type	Rutile Basic

Typical Weld Metal Analysis %			
C	Mn	Si	Cr
4.5	1.0	0.8	31.8

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 350.0 mm	115-170 A	24 V	62 %	26	85 sec	1.6 kg/h
4.0 x 450.0 mm	130-210 A	26 V	64 %	14	135 sec	2.0 kg/h
5.0 x 450.0 mm	150-300 A	26 V	64 %	9	140 sec	2.9 kg/h