

OK 83.28

Basic coated electrode recommended for recovery of railway material, brake shoes, rails, needles and intersections, wheel floor and friezes, rolling stock of machines, rollers, guide wheels, pins, links; worn parts in low alloy or cast steels, shafts, cylinders, forge stools, large gears, etc.

Specifications	
Classifications	EN 14700 : E Z Fe1 DIN 8555 (1985) : E 1-UM-350

Welding Current	DC+, AC
Alloy Type	Martensitic steel
Coating Type	Basic

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	110-140 A	21 V	80 %	50	68 sec	1.1 kg/h
4.0 x 450.0 mm	150-190 A	23 V	76 %	22	92 sec	1.8 kg/h
5.0 x 450.0 mm	190-260 A					0.0 kg/h
6.0 x 450.0 mm	230-320 A	24 V	76 %	1053	110 sec	3.1 kg/h