

# OK 86.30

SMAW

Type Rutile-basic

E7-UM-200-KR

## Description

OK 86.30 deposits an austenitic, chromium-manganese steel with excellent work-hardening properties and initial resistance to abrasion. The high chromium content also produces good resistance to heat and corrosion.

The electrode is used for surfacing and building up manganese steels on crusher hammers, dredger buckets and so on.

### Application:

It is recommended to limit the heat input and utilise an interpass temperature below 200°C.

### Welding current

DC+ -, AC OCV 60 V



## Classifications

DIN 8555 E7-UM-200-KR

## Typical all weld metal composition, %

| C   | Si  | Mn   | Cr   | Ni  | V     |
|-----|-----|------|------|-----|-------|
| 0.3 | 0.5 | 14.0 | 18.0 | 1.5 | < 0.1 |

## Typical mech. properties all weld metal

Values valid for welding on mild steel and on austenitic manganese steel.

|  |            |
|--|------------|
| Weld metal hardness, a w (1-3 layers)  | 190-210 HB |
| Weld metal hardness, w h (1- 3 layers) | 40-44 HRC  |
| Machinability                          | Grinding   |
| Impact resistance                      | Excellent  |

## 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        | 105-155            | 23             | 0.61                           | 23                                 | 1.6                            | 97                             |
| 4.0          | 450        | 120-200            | 25             | 0.61                           | 15                                 | 2.4                            | 99                             |