

OK Autrodur 58 G M

A copper coated, low-alloyed solid GMAW wire used for hard facing and building up highly wear resistant layers on machinery parts like shafts, feed screws, driving rollers, cutting tools, dies and other parts subjected to strong wear. Hardness of the weld metal becomes 50-60 HRC.

Specifications	
Classifications	EN 14700 : ZFe8
Alloy Type	Low alloyed (1.1 % C, 2 % Mn, 1.8 % Cr, 0.2 % Ti)
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Weld Metal Analysis %						
C	Mn	Si	S	P	Cr	Ti
Shielding gas: 80Ar20CO2						
0.9	1.6	0.4	0.01	0.01	1.6	0.10
Shielding gas: CO2						
0.8	1.5	0.4	0.01	0.01	1.6	0.08

Typical Wire Composition %			
C	Mn	Si	Cr
1.04	1.87	0.48	1.82

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (0.047 in.)	120-350 A	20-33 V	2.7-12.4 m/min (106-488 in./min)	1.5-6.6 kg/h (3.3-14. lbs/h)