

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.

Classifications Wire Electrode	EN 14700 : ZFe8
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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
0.9	1.6	0.4	0.01	0.01	1.6	0.10

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
1.0 mm (0.040 in.)	80-280 A	18-28 V	2.7-14.7 m/min (106-579 in./min)	1.0-5.4 kg/h (2.2-11. lb/h)
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. lb/h)