OK 67.13



Austenitic stainless steel electrode for welding 25Cr20Ni steels. The weld metal does not contain any measureable ferrite and resists scaling up to 1100-1150 °C.

Specifications	
Classifications	EN ISO 3581-A : E 25 20 R 1 2 SFA/AWS A5.4 : E310-16 Werkstoffnummer : 1.4842
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+, AC
Ferrite Content	FN 0
Alloy Type	Austenitic CrNi
Coating Type	Basic Rutile
Min AC OCV	65

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	430 MPa (62 ksi)	600 MPa (87 ksi)	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
AWS		
As Welded	20 °C (68 °F)	90 J (67 ft-lb)
ISO		
As Welded	20 °C (68 °F)	83 J (61 ft-lb)

Typical Weld Metal Analysis %				
C	**Mn**	**Si**	**Ni**	**Cr**
0.12	1.9	0.6	21.1	25.6

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.5 x 300 mm (0.098 x 11.8 in.)	50-85 A	21 V	51 %	42 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	65-120 A	24 V	51 %	58 sec	1.2 kg/h (2.6 lbs/h)
4.0 x 350 mm (5/32 x 13.8 in.)	70-160 A	28 V	51 %	61 sec	1.7 kg/h (3.7 lbs/h)