OK 67.50



OK 67.50 is an acid rutile coated type for welding of austenitic-ferritic stainless steels of CrNiMoN 22 5 3 - and CrNiN 23 4-types. The duplex all weld metal offers a high strength level combined with good ductility. The pitting corrosion resistance is good and the all weld metal is not sensitive for stress corrosion cracking.

Specifications	
Classifications	EN ISO 3581-A : E 22 9 3 N L R 3 2 SFA/AWS A5.4 : E2209-17 CSA W48 : E2209-17 Werkstoffnummer : 1.4462
Approvals	ABS : E2209-17 ABS : Stainless* BV : 2209 CE : EN 13479 CWB : E2209-17 DNV : Duplex RINA : 2209 UKCA : EN 13479 VdTÜV : 04368

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

Welding Current	DC+, AC
Ferrite Content	FN 35-50
Alloy Type	Duplex CrNiMoN
Coating Type	Acid Rutile
Min AC OCV	60

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	691 MPa (100 ksi)	857 MPa (124 ksi)	25 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-30 °C (-22 °F)	41 J (30 ft-lb)

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**FN WRC-92**
0.03	0.8	0.8	8.8	23.2	3.2	0.16	42

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.0 x 300 mm (5/64 x 11.8 in.)	30-65 A	29 V	55 %	33 sec	0.7 kg/h (1.5 lbs/h)
2.5 x 300 mm (0.098 x 11.8 in.)	50-90 A	27 V	58 %	38 sec	1.0 kg/h (2.2 lbs/h)
3.2 x 350 mm (1/8 x 13.8 in.)	80-120 A	28 V	58 %	55 sec	1.4 kg/h (3.1 lbs/h)

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Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
4.0 x 350 mm (5/32 x 13.8 in.)	90-160 A	29 V	58 %	59 sec	1.9 kg/h (4.2 lbs/h)
5.0 x 350 mm (0.197 x 13.8 in.)	150-220 A	30 V	58 %	64 sec	2.8 kg/h (6.2 lbs/h)