OK 67.75



Basic coated stainless steel electrode for welding steels of the type 24Cr13Ni, welding transition layers when surfacing mild steel with stainless, joining dissimilar steels and welding root runs in the stainless side of clad steels.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 L B 4 2 SFA/AWS A5.4 : E309L-15 Werkstoffnummer : 1.4332
Approvals	ABS : Stainless CE : EN 13479 DNV : NV 309 LR : SS/CMn UKCA : EN 13479 VdTÜV : 00633

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

Welding Current	DC+
Ferrite Content	FN 8-15
Alloy Type	Austenitic CrNi
Coating Type	Basic

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
AWS			
As Welded	470 MPa	600 MPa	35 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
AWS		
As Welded	20 °C	75 J
As Welded	-50 °C	64 J
As Welded	-80 °C	55 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.04	2.0	0.3	12.9	23.5	0.06	11

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 300 mm	50-80 A	22 V	73 %	42 sec	1.1 kg/h
3.2 x 350 mm	80-120 A	24 V	73 %	60 sec	1.5 kg/h
4.0 x 350 mm	80-150 A	26 V	73 %	62 sec	2.3 kg/h