OK 68.55



Stainless MMA electrode for welding austenitic-ferritic stainless steels of the so called "Superduplex-type", e.g. SAF 2507 and Zeron 100.

Specifications	
Classifications	EN ISO 3581-A : E 25 9 4 N L B 4 2 SFA/AWS A5.4 : E2594-15 Werkstoffnummer : (1.4410)
Approvals	DNV : Duplex

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

Welding Current	DC+
Ferrite Content	FN 35-50
Alloy Type	Austenitic CrNiMo
Coating Type	Basic

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	700 MPa	900 MPa	28 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	90 J
As Welded	-20 °C	70 J
As Welded	-40 °C	55 J
As Welded	-60 °C	45 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**FN WRC-92**
0.03	0.9	0.6	10.4	25.2	4.3	0.23	45

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	23 V	62 %	48 sec	0.8 kg/h
3.2 x 350 mm	60-100 A	23 V	63 %	68 sec	1.1 kg/h
4.0 x 350 mm	100-140 A	23 V	62 %	70 sec	1.6 kg/h