OK 69.33



Stainless steel electrode giving a fully austenitic weld metal highly resistant to sulphuric acid. The resistance to intergranular and pitting corrosion is good.

Specifications	
Classifications	EN ISO 3581-A : E 20 25 5 Cu N L R 3 2 SFA/AWS A5.4 : E385-16 Werkstoffnummer : 1.4519
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 02723

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

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

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	410 MPa	590 MPa	35 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	80 J
As Welded	-140 °C	70 J

Typical Weld Metal Analysis %								
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**Cu**	**N**	**FN WRC-92**
0.03	1.0	0.5	25.5	20.5	4.8	1.70	0.10	0

Deposition Data					
Diameter	**Amps**	**Volts**	**Efficiency (Per)**	**Fusion time per electrode at 90Per I max**	**Deposition rate at 90Per**
2.5 x 300 mm	60-85 A	24 V	60 %	44 sec	0.9 kg/h
3.2 x 350 mm	85-130 A	27 V	58 %	60 sec	1.5 kg/h
4.0 x 350 mm	95-180 A	29 V	51 %	64 sec	1.9 kg/h