OK 67.45



Austenitic stainless steel electrode giving a weld metal with less than 5 % ferrite. The tough weld metal has an excellent crack resistance, also when welding steels with very poor weldability. Suitable for joining 12 to 14 % manganese steel with itself or other steels. Also suitable for buffer layers before hard facing.

Specifications	
Classifications	EN ISO 3581-A : E 18 8 Mn B 2 2 SFA/AWS A5.4 : (E307-15)
Approvals	ABS : Stainless CE : EN 13479 UKCA : EN 13479 VdTÜV : 01580

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

Welding Current	DC+
Ferrite Content	FN <5
Alloy Type	Stainless austenitic CrNiMn
Coating Type	Lime Basic

Tensile_Properties			
Testing Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	470 MPa	605 MPa	35 %

Charpy Testing		
Testing Condition	**Testing Temp**	**Impact Value**
ISO		
As Welded	20 °C	85 J
As Welded	-60 °C	50 J

Typical Weld Metal Analysis %						
C	**Mn**	**Si**	**Ni**	**Cr**	**N**	**FN WRC-92**
0.09	6.3	0.3	9.1	18.8	0.06	2

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	58 %	50 sec	0.7 kg/h
3.2 x 350 mm	70-100 A	24 V	60 %	71 sec	1.1 kg/h
4.0 x 350 mm	80-140 A	24 V	60 %	73 sec	1.5 kg/h
5.0 x 350 mm	150-200 A	25 V	60 %	80 sec	2.2 kg/h