

OK 68.17

OK 68.17 is a coated electrode designed for the welding of stainless-steel castings of the 13Cr4NiMo type, for example. OK 68.17 can be welded in all positions apart from vertical down.

Specifications

Classifications	EN 14700 : E Fe7 EN ISO 3581-A : E 13 4 R 3 2 SFA/AWS A5.4 : E410NiMo-16 Werkstoffnummer : 1.4351
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Welding Current	DC+, AC
Diffusible Hydrogen	<8.0 ml/100g
Alloy Type	Martensitic 13Cr4Ni-Mo type
Coating Type	Rutile Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
Stress relieved+ 8 hour(s) 600 °C (1112 °F)	650 MPa (94 ksi)	870 MPa (126 ksi)	17 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
Stress relieved+	20 °C (68 °F)	45 J (33 ft-lb)
Stress relieved+	-10 °C (14 °F)	45 J (33 ft-lb)
Stress relieved+	-40 °C (-40 °F)	40 J (30 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.02	0.6	0.4	4.6	12.0	0.6

Deposition Data

Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.5 x 350.0 mm (0.098 x 13.8 in.)	55-100 A	21 V	62 %	61 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-135 A	21 V	59 %	66 sec	1.2 kg/h (2.6 lbs/h)
4.0 x 450.0 mm (5/32 x 17.7 in.)	90-190 A	24 V	59 %	92 sec	1.7 kg/h (3.7 lbs/h)