

OK 68.25

Basic coated electrode for welding corrosion resistant martensitic and martensitic-ferritic rolled, forged and cast steels, for example castings of 13Cr4NiMo-type.

Specifications

Classifications	EN 14700 : E Fe7 EN ISO 3581-A : E 13 4 B 4 2 SFA/AWS A5.4 : E410NiMo-15 Werkstoffnummer : 1.4351
------------------------	--

Welding Current	DC+
Diffusible Hydrogen	<5.0 ml/100g
Alloy Type	Martensitic-ferritic
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
PWHT 8 hour(s) 600 °C	680 MPa	900 MPa	17 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
PWHT	20 °C	65 J
PWHT	0 °C	60 J
PWHT	-20 °C	55 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.04	0.6	0.4	4.5	12.2	0.6

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
3.2 x 450.0 mm	90-150 A	28 V	64 %	63 sec	1.6 kg/h
4.0 x 450.0 mm	110-190 A	28 V	66 %	73 sec	2.2 kg/h
5.0 x 450.0 mm	140-250 A	27 V	67 %	86 sec	3.1 kg/h