

## OK 67.75

Basic coated stainless steel electrode for welding steels of the type 24Cr13Ni, welding transition layers when surfacing mild steel with stainless, joining dissimilar steels and welding root runs in the stainless side of clad steels.

| Specifications         |                                                                                                           |
|------------------------|-----------------------------------------------------------------------------------------------------------|
| <b>Classifications</b> | EN 1600 : E 23 12 L B 4 2<br>SFA/AWS A5.4 : E309L-15<br>Werkstoff Nr. : 1.4332                            |
| <b>Approvals</b>       | ABS Stainless<br>DNV 309<br>LR SS to C/Mn Steels<br>Sepros UNA 272580<br>Seproz UNA 272580<br>VdTÜV 00633 |

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

|                        |                 |
|------------------------|-----------------|
| <b>Welding Current</b> | DC+             |
| <b>Ferrite Content</b> | FN 8-15         |
| <b>Alloy Type</b>      | Austenitic CrNi |
| <b>Coating Type</b>    | Basic           |

| Typical Tensile Properties |                      |                    |            |
|----------------------------|----------------------|--------------------|------------|
| Conditional Statement      | Yield Strength       | Tensile Strength   | Elongation |
| As welded                  | 470 MPa ( 68.2 ksi ) | 600 MPa ( 87 ksi ) | 35 %       |

| Typical Charpy V-Notch Properties |                     |
|-----------------------------------|---------------------|
| Testing Temperature               | Impact Value        |
| 20 °C ( 68 °F )                   | 75 J ( 55 ft-lb )   |
| -50 °C ( -58 °F )                 | 64 J ( 47 ft-lb )   |
| -80 °C ( -112 °F )                | 55 J ( 40.5 ft-lb ) |

| Deposition Data                   |           |         |                             |                                    |                          |                           |
|-----------------------------------|-----------|---------|-----------------------------|------------------------------------|--------------------------|---------------------------|
| Diameter                          | Current   | Voltage | kg weld metal/kg electrodes | Number of electrodes/kg weld metal | Burn-off Time /Electrode | Deposition Rate           |
| 2.5 x 300 mm<br>( 3/32 x 12 in. ) | 50-80 A   | 22 V    | 0.73                        | 78                                 | 42 sec                   | 1.1 kg/h<br>( 2.4 lbs/h ) |
| 3.2 x 350 mm<br>( 1/8 x 14 in. )  | 80-110 A  | 24 V    | 0.73                        | 39                                 | 60 sec                   | 1.5 kg/h<br>( 3.3 lbs/h ) |
| 4.0 x 350 mm<br>( 5/32 x 14 in. ) | 80-150 A  | 26 V    | 0.73                        | 25                                 | 62 sec                   | 2.3 kg/h<br>( 5.1 lbs/h ) |
| 5.0 x 350 mm<br>( 3/16 x 14 in. ) | 160-220 A | 27 V    | 0.73                        | 17                                 | 65 sec                   | 3.4 kg/h<br>( 7.5 lbs/h ) |