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 1600 : E 20 25 5 Cu N L R 3 2 SFA/AWS A5.4 : E385-16 Werkstoff Nr. : 1.4519
Approvals	CE EN 13479 Sepros UNA 272580 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

Typical Tensile Properties			
Conditional Statement	**Yield Strength**	**Tensile Strength**	**Elongation**
As welded	410 MPa (59.5 ksi)	590 MPa (85.6 ksi)	35 %

Typical Charpy V-Notch Properties	
Testing Temperature	**Impact Value**
20 °C (68 °F)	80 J (59 ft-lb)
-140 °C (-220 °F)	70 J (52 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 (3/32 x 12 in.)	60-85 A	24 V	0.60	91	44 sec	0.9 kg/h (2.0 lbs/h)
3.2 x 350 mm (1/8 x 14 in.)	85-130 A	27 V	0.58	41	60 sec	1.5 kg/h (3.3 lbs/h)
4.0 x 350 mm (5/32 x 14 in.)	95-180 A	29 V	0.51	30	64 sec	1.9 kg/h (4.2 lbs/h)