

OK 68.53

Stainless MMA electrode for welding austenitic-ferritic stainless steels of the so called Superduplex types i.e. steel grade SAF 2507 and Zeron 100.

Specifications	
Classifications	EN ISO 3581-A : E 25 9 4 N L R 32 SFA/AWS A5.4 : E2594-16 Werkstoffnummer : (1.4410)
Approvals	CE : EN 13479 DNV-GL : Duplex UKCA : EN 13479 VdTÜV : 07377

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

Welding Current	DC+, AC
Ferrite Content	FN 35-50
Alloy Type	Austenitic-ferritic CrNiMo
Coating Type	Basic Rutile

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	700 MPa	850 MPa	30 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-40 °C	40 J
As Welded	20 °C	50 J

Typical Weld Metal Analysis %						
C	Si	Ni	Cr	Mo	N	FN WRC-92
0.03	0.6	10.3	25.2	4	0.25	39

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	55-85 A	22 V	60 %	43 sec	0.9 kg/h
3.2 x 350.0 mm	70-110 A	22 V	60 %	62 sec	1.2 kg/h
4.0 x 350.0 mm	80-150 A	23 V	60 %	67 sec	1.7 kg/h