

OK 67.62

OK 67.62 is a synthetic, stainless, high-recovery electrode of the 24Cr12Ni type for welding stainless steel to unalloyed steel. The composition is balanced to produce good crack resistance when welding stainless steel to mild steel. The bead appearance is outstanding in both butt welds and fillet welds.

Specifications

Classifications	EN 1600 : E Z 23 12 R 7 3 SFA/AWS A5.4 : E309-26 Werkstoff Nr. : 1.4332
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	440 MPa	560 MPa	36 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	+20 °C	60 J
As Welded	-60 °C	42 J

Deposition Data

Diameter	Current	Voltage	Efficiency (%)
3.2 mm	110-165 A	30 V	170 %
4 mm	150-230 A	35 V	170 %
5 mm	200-310 A	38 V	170 %