

OK 68.17

A rutile-basic electrode for welding martensitic 13Cr4Ni-Mo type steels.

Specifications

Classifications	EN 14700 : E Fe7 EN ISO 3581-A : E 13 4 R 3 2 SFA/AWS A5.4 : E410NiMo-16 Werkstoffnummer : 1.4351
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Welding Current	DC+, AC
Diffusible Hydrogen	<8.0 ml/100g
Alloy Type	Martensitic 13Cr4Ni-Mo type
Coating Type	Rutile Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
Stress relieved+ 8 hour(s) 600 °C	650 MPa	870 MPa	17 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
Stress relieved+	20 °C	45 J
Stress relieved+	-10 °C	45 J
Stress relieved+	-40 °C	40 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.02	0.6	0.4	4.6	12.0	0.6

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 350.0 mm	55-100 A	21 V	62 %	61 sec	0.8 kg/h
3.2 x 350.0 mm	65-135 A	21 V	59 %	66 sec	1.2 kg/h
4.0 x 450.0 mm	90-190 A	24 V	59 %	92 sec	1.7 kg/h