

OK 69.25

Basic coated stainless electrode for welding corrosion resistant, non-magnetic and cryogenic stainless steels. The electrode is giving a fully austenitic Cr-Ni-Mo weld metal with increased Mn- and N-content.

Specifications

Classifications	EN ISO 3581-A : E 20 16 3 Mn N L B 4 2 SFA/AWS A5.4 : E316LMn-15 Werkstoffnummer : 1.4455
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Welding Current	DC+
Ferrite Content	FN <0.5
Alloy Type	CrNiMo
Coating Type	Basic

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	450 MPa	650 MPa	35 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	20 °C	90 J
As Welded	-196 °C	50 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.04	6.5	0.5	16.0	19.0	3.0	0.15	0

Deposition Data

Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
3.2 x 350.0 mm	70-100 A	24 V	62 %	72 sec	1.2 kg/h
4.0 x 350.0 mm	100-140 A	25 V	64 %	74 sec	1.8 kg/h