OK 67.53

Thin coated rutile MMA-electrode especially designed for pipe welding of duplex stainless steel. i.e. UNS S31803, CrNiMoN22-5-3, CrNiN23-4. Ideal for root runs and positional welding.

Specifications	
Classifications	EN ISO 3581-A : E 22 9 3 N L R 1 2 SFA/AWS A5.4 : (E2209-16) Werkstoffnummer : 1.4462
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 05422

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

Welding Current	DC+, AC
Ferrite Content	FN 30-45
Alloy Type	Duplex CrNi
Coating Type	Rutile

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	680 MPa	860 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	-20 °C	40 J
As Welded	20 °C	48 J
As Welded	-30 °C	37 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**Ferrite FN**
0.03	0.7	1.0	9.3	23.7	3.4	0.18	40

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
2.5 x 300.0 mm	30-80 A	23 V	63 %	54 sec	0.7 kg/h
3.2 x 350.0 mm	70-110 A	27 V	57 %	64 sec	1.0 kg/h