

## OK 68.15

Stainless steel MMA electrode, giving a weld metal of the 13% Cr type. Intended for welding steels of similar composition when CrNi alloyed austenitic stainless steel electrodes cannot be used, e.g. when the construction will be exposed to aggressive sulphuric gases.

### Specifications

|                        |                                                                                                      |
|------------------------|------------------------------------------------------------------------------------------------------|
| <b>Classifications</b> | EN 14700 : E Fe7<br>EN ISO 3581-A : E 13 B 4 2<br>SFA/AWS A5.4 : E410-15<br>Werkstoffnummer : 1.4009 |
|------------------------|------------------------------------------------------------------------------------------------------|

|                        |            |
|------------------------|------------|
| <b>Welding Current</b> | DC+        |
| <b>Alloy Type</b>      | 13% Cr     |
| <b>Coating Type</b>    | Lime Basic |

### Typical Tensile Properties

| Condition                           | Yield Strength | Tensile Strength | Elongation |
|-------------------------------------|----------------|------------------|------------|
| <b>AWS</b>                          |                |                  |            |
| Stress Relieved<br>1 hour(s) 750 °C | 370 MPa        | 520 MPa          | 25 %       |

### Typical Charpy V-Notch Properties

| Condition       | Testing Temperature | Impact Value |
|-----------------|---------------------|--------------|
| <b>AWS</b>      |                     |              |
| Stress Relieved | 20 °C               | 55 J         |
| Stress Relieved | -20 °C              | 20 J         |
| Stress Relieved | 0 °C                | 35 J         |

### Typical Weld Metal Analysis %

### Deposition Data

| Diameter       | Current   | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
|----------------|-----------|---------|----------------|----------------------------------------|-----------------|
| 2.5 x 350.0 mm | 65-115 A  | 25 V    | 62 %           | 48 sec                                 | 1.0 kg/h        |
| 3.2 x 450.0 mm | 90-160 A  | 25 V    | 63 %           | 71 sec                                 | 1.5 kg/h        |
| 4.0 x 450.0 mm | 120-220 A | 30 V    | 57 %           | 73 sec                                 | 2.0 kg/h        |