

OK 68.55

Stainless MMA electrode for welding austenitic-ferritic stainless steels of the so called "Superduplex-type", e.g. SAF 2507 and Zeron 100.

Specifications

Classifications	EN ISO 3581-A : E 25 9 4 N L B 4 2 SFA/AWS A5.4 : E2594-15 Werkstoffnummer : (1.4410)
Approvals	DNV-GL : Duplex

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

Welding Current	DC+
Ferrite Content	FN 35-50
Alloy Type	Austenitic CrNiMo
Coating Type	Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	700 MPa	900 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As Welded	-40 °C	55 J
As Welded	-60 °C	45 J
As Welded	-20 °C	70 J
As Welded	20 °C	90 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.03	0.9	0.6	10.4	25.2	4.3	0.23	45

Deposition Data

Diameter	Current	Voltage	Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300.0 mm	50-80 A	23 V	62 %	48 sec	0.8 kg/h
3.2 x 350.0 mm	60-100 A	23 V	63 %	68 sec	1.1 kg/h
4.0 x 350.0 mm	100-140 A	23 V	62 %	70 sec	1.6 kg/h