

OK 67.43

Austenitic stainless steel MMA-electrode giving a weld metal of the CrNiMn-type. The weld metal, which contains a small amount of uniformly distributed ferrite, is tough and has an excellent crack resistance. Suitable for joining 13%Mn-steels and such steels to other steels. Also suitable for welding of other steels with very poor weldability.

Specifications	
Classifications	EN 14700 : E Fe10 EN ISO 3581-A : E 18 8 Mn R 1 2 SFA/AWS A5.4 : (E307-16) Werkstoffnummer : 1.4370
Approvals	CE : EN 13479 DB : 30.039.07 UKCA : EN 13479 VdTÜV : 06797

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

Welding Current	AC, DC+
Ferrite Content	FN <5
Alloy Type	Austenitic. CrNiMn
Coating Type	Rutile Basic

Tensile_Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	440 MPa	630 MPa	35 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-60 °C	52 J
As Welded	20 °C	80 J

Typical Weld Metal Analysis %						
C	Mn	Si	Ni	Cr	N	FN WRC-92
0.08	5.4	0.8	9.1	18.4	0.08	2

Deposition Data					
Diameter	Amps	Volts	Efficiency (Per)	Fusion time per electrode at 90Per I max	Deposition rate at 90Per
2.5 x 300.0 mm	60-80 A	22 V	51 %	46 sec	0.8 kg/h
3.2 x 350.0 mm	90-115 A	23 V	54 %	54 sec	1.3 kg/h
4.0 x 350.0 mm	100-150 A	23 V	56 %	61 sec	1.7 kg/h
5.0 x 450.0 mm	130-210 A	24 V	60 %	86 sec	2.8 kg/h