

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

Classifications	EN 14700 : E Fe7 EN ISO 3581-A : E 13 B 4 2 SFA/AWS A5.4 : E410-15 Werkstoffnummer : 1.4009
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Welding Current	DC+
Alloy Type	13% Cr
Coating Type	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
Stress Relieved 1 hour(s) 750 °C	370 MPa	520 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
Stress Relieved	20 °C	55 J
Stress Relieved	-20 °C	20 J
Stress Relieved	0 °C	35 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.04	0.3	0.4	0.1	12.9

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