OK 69.25

Basic coated stainless electrode for welding corrosion resistant, non-magnetic and cryogenic stainless steels. The electrode is giving a fully austenitic Cr-Ni-Mo weld metal with increased Mn- and N-content.

Specifications	
Classifications	EN ISO 3581-A : E 20 16 3 Mn N L B 4 2 SFA/AWS A5.4 : E316LMn-15 Werkstoffnummer : 1.4455

Welding Current	DC+
Ferrite Content	FN <0.5
Alloy Type	CrNiMo
Coating Type	Basic

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
ISO			
As Welded	450 MPa	650 MPa	35 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	-196 °C	50 J
As Welded	20 °C	90 J

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**Ferrite FN**
0.04	6.5	0.5	16.0	19.0	3.0	0.15	0

Deposition Data					
Diameter	**Current**	**Voltage**	**Efficiency (%)**	**Fusion time per electrode at 90% I max**	**Deposition Rate**
3.2 x 350.0 mm	70-100 A	24 V	62 %	72 sec	1.2 kg/h
4.0 x 350.0 mm	100-140 A	25 V	64 %	74 sec	1.8 kg/h