

OK 67.56

Acid rutile coated MMA-electrode for welding lean ferritic-austenitic (duplex) stainless steels. This electrode provides excellent mechanical properties combined with a medium corrosion resistance. It is used for welding the majority of lean duplex types such as S32001 (1.4482), S82011, S32101 (1.4162), S32202 (1.4062), S32304 (1.4362). It can also be used to weld grade S32003 if slightly undermatching corrosion resistance is accepted. It is less suitable for 1.4655 type material where Cu alloying is required. Typical applications are desalination plants, pipes, storage tanks, floodgates, footbridges and containers.

Specifications

Classifications	EN ISO 3581-A : E Z 23 7 N L R
Approvals	CE : EN 13479

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

Welding Current	DC+, AC
Ferrite Content	FN 35-65
Alloy Type	Duplex CrNiMoN
Coating Type	Acid Rutile

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	609 MPa	754 MPa	26 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
ISO		
As Welded	-30 °C	38 J
As Welded	20 °C	47 J

Deposition Data

Diameter	Amps	Volts	kg weld metal/kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90Per I max	Deposition Rate
2.5 x 300 mm	50-80 A	25 V	0.61	83	52 sec	0.8 kg/h
3.2 x 350 mm	60-120 A	27 V	0.59	46	58 sec	1.3 kg/h
4.0 x 350 mm	100-170 A	27 V	0.61	29	62 sec	2.0 kg/h