OK 67.55

OK 67.55 is a basic coated electrode especially designed for welding duplex stainless steels i, e. UNS S31803. The deposited weld metal gives very high ductility down to -50°C/-60°C. Particularly suitable for welding duplex pipes in offshore applications.

Specifications	
Classifications	EN ISO 3581-A : E 22 9 3 N L B 2 2 SFA/AWS A5.4 : E2209-15 Werkstoffnummer : 1.4462
Approvals	DNV-GL : Duplex VdTÜV : 06774

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	650 MPa (94 ksi)	800 MPa (116 ksi)	28 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
ISO		
As Welded	-20 °C (-4 °F)	85 J (63 ft-lb)
As Welded	-60 °C (-76 °F)	65 J (48 ft-lb)
As Welded	20 °C (68 °F)	100 J (74 ft-lb)
As Welded	-40 °C (-40 °F)	75 J (56 ft-lb)

Typical Weld Metal Analysis %							
C	**Mn**	**Si**	**Ni**	**Cr**	**Mo**	**N**	**FN WRC-92**
0.04	1.0	0.7	9.1	23.2	3.2	0.15	41

Deposition Data					
Diameter	**Current**	**Voltage**	**Deposition Efficiency (%)**	**Burn-off Time /Electrode**	**Deposition Rate @ 90% I max**
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-80 A	23 V	59 %	49 sec	0.8 kg/h (1.8 lbs/h)
3.2 x 350.0 mm (1/8 x 13.8 in.)	65-115 A	24 V	59 %	61 sec	1.2 kg/h (2.6 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	80-140 A	24 V	60 %	74 sec	1.5 kg/h (3.3 lbs/h)