

OK 67.45



Austenitic stainless-steel electrode producing a weld metal with less than 5% ferrite. The tough weld metal has excellent crack resistance, even when welding steels with very poor weldability. Suitable for joining 12-14% manganese steel to itself or other steels. Also suitable for buffer layers before hardfacing.

Classifications:	EN ISO 3581-A:E 18 8 Mn B 2 2, SFA/AWS A5.4:(E307-15)
Approvals:	CE EN 13479, Seproz UNA 272580, ABS Stainless, VdTÜV 01580

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

Welding Current:	DC+
Ferrite Content:	FN <5
Alloy Type:	Stainless austenitic CrNiMn
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	470 MPa	605 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	85 J
As welded	-60 °C	50 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	N	Ferrite FN
0.09	6.3	0.3	9.1	18.8	0.06	1

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.5 x 300 mm	50-80 A	23 V	0.58	102	50 s	0.7 kg/h
3.2 x 350 mm	70-100 A	24 V	0.60	51	71 s	1.1 kg/h
4.0 x 350 mm	80-140 A	24 V	0.60	33	73 s	1.5 kg/h
5.0 x 350 mm	150-200 A	25 V	0.60	22	80 s	2.2 kg/h