

# OK 68.15



OK 68.15 is a stainless-steel electrode which deposits a ferritic 13Cr weld metal. OK 68.15 is designed for welding steels of similar composition, when CrNi-alloyed austenitic stainless steel electrodes cannot be used, e.g. when the structure is going to be exposed to aggressive sulphuric gases. Depending on the welding parameters, the structure and consequently the mechanical properties of untreated weld metal can vary within fairly large limits.

<b>Classifications:</b>	EN 14700:E Fe7, EN ISO 3581-A:E 13 B 4 2, SFA/AWS A5.4:E410-15, Werkstoffnummer :1.4009
<b>Approvals:</b>	Sepro UN A 272580

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

<b>Welding Current:</b>	DC+
<b>Alloy Type:</b>	13% Cr
<b>Coating Type:</b>	Lime Basic

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>AWS</b>			
Stress relieved 1 hr 750 °C	370 MPa	520 MPa	25 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>AWS</b>		
Stress relieved 6 hr 750 °C	20 °C	55 J
Stress relieved 6 hr 750 °C	0 °C	35 J
Stress relieved 6 hr 750 °C	-20 °C	20 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	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 350 mm	65-115 A	25 V	0.62	73	48 s	1.0 kg/h
3.2 x 450 mm	90-160 A	25 V	0.63	33	71 s	1.5 kg/h
4.0 x 450 mm	120-220 A	30 V	0.57	24	73 s	2.0 kg/h