

OK 68.17



OK 68.17 is a coated electrode designed for the welding of stainless-steel castings of the 13Cr4NiMo type, for example. OK 68.17 can be welded in all positions apart from vertical down.

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|-------------------------|-----------------------------------------------------------------------------------------------|
| Classifications: | EN 14700:E Fe7, EN ISO 3581-A:E 13 4 R 3 2, SFA/AWS A5.4:E410NiMo-16, Werkstoffnummer :1.4351 |
| Approvals: | Seproz UNA 272580 |

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

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|-----------------------------|-----------------------------|
| Welding Current: | DC+, AC |
| Diffusible Hydrogen: | <8.0 ml/100g |
| Alloy Type: | Martensitic 13Cr4Ni-Mo type |
| Coating Type: | Rutile Basic |

Typical Tensile Properties

| Condition | Yield Strength | Tensile Strength | Elongation |
|-----------------------------|----------------|------------------|------------|
| ISO | | | |
| Stress relieved 8 hr 600 °C | 650 MPa | 870 MPa | 17 % |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------------------------|---------------------|--------------|
| ISO | | |
| Stress relieved 8 hr 600 °C | 20 °C | 45 J |
| Stress relieved 8 hr 600 °C | -10 °C | 45 J |
| Stress relieved 8 hr 600 °C | -40 °C | 40 J |

Typical Weld Metal Analysis %

| C | Mn | Si | Ni | Cr | Mo |
|------|-----|-----|-----|------|-----|
| 0.02 | 0.6 | 0.4 | 4.6 | 12.0 | 0.6 |

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 | 55-100 A | 21 V | 0.62 | 73 | 61 s | 0.8 kg/h |
| 3.2 x 350 mm | 65-135 A | 21 V | 0.59 | 45 | 66 s | 1.2 kg/h |
| 4.0 x 450 mm | 90-190 A | 24 V | 0.59 | 23 | 92 s | 1.7 kg/h |