

OK 68.53



OK 68.53 is a coated electrode for welding austenitic-ferritic steels of Super Duplex types, e.g. SAF 2507 and Zeron 100. OK 68.53 has good welding characteristics in all positions and the slag is easily detachable.

Classifications:	EN ISO 3581-A:E 25 9 4 N L R 32, SFA/AWS A5.4:E2594-16, Werkstoffnummer :(1.4410)
Approvals:	DNV , CE EN 13479, VdTÜV 07377

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

Welding Current:	DC+, AC
Ferrite Content:	FN 35-50
Alloy Type:	Austenitic-ferritic CrNiMo
Coating Type:	Basic Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	700 MPa	850 MPa	30 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	50 J
As welded	-40 °C	40 J

Typical Weld Metal Analysis %

C	Si	Ni	Cr	Mo	N	Ferrite FN
0.03	0.6	10.3	25.2	4	0.25	39

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	55-85 A	22 V	0.60	94	43 s	0.9 kg/h
3.2 x 350 mm	70-110 A	22 V	0.60	47	62 s	1.2 kg/h
4.0 x 350 mm	80-150 A	23 V	0.60	32	67 s	1.7 kg/h