

# OK 69.33



OK 69.33 is a stainless-steel electrode which deposits a fully austenitic weld metal with increased resistance to sulphuric acid. The weld metal of OK 69.33 also has good resistance to intergranular and pitting corrosion.

<b>Classifications:</b>	EN ISO 3581-A:E 20 25 5 Cu N L R 3 2, SFA/AWS A5.4:E385-16, Werkstoffnummer :1.4519
<b>Approvals:</b>	CE EN 13479, Seproz UNA 272580, VdTÜV 02723

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

<b>Welding Current:</b>	AC, DC+
<b>Ferrite Content:</b>	FN 0
<b>Alloy Type:</b>	Austenitic CrNi
<b>Coating Type:</b>	Basic Rutile

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>			
As welded	410 MPa	590 MPa	35 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As welded	20 °C	80 J
As welded	-140 °C	70 J

## Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	Cu	N	Ferrite FN
0.03	1.0	0.5	25.5	20.5	4.8	1.70	0.10	0

## 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	60-85 A	24 V	0.60	91	44 s	0.9 kg/h
3.2 x 350 mm	85-130 A	27 V	0.58	41	60 s	1.5 kg/h
4.0 x 350 mm	95-180 A	29 V	0.51	30	64 s	1.9 kg/h