OK 67.50

OK 67.50 is an acid rutile coated type for welding of austenitic-ferritic stainless steels of CrNiMoN 22 5 3 - and CrNiN 23 4-types. The duplex all weld metal offers a high strength level combined with good ductility. The pitting corrosion resistance is good and the all weld metal is not sensitive for stress corrosion cracking.

Classifications:	EN ISO 3581-A:E 22 9 3 N L R 3 2, SFA/AWS A5.4:E2209-17, CSA W48:E2209-17, Werkstoffnummer :1.4462
Approvals:	CE EN 13479, Seproz UNA 272580, ABS Stainless*, BV 2209, CWB CSA W48: E2209-17, DNV For duplex SS, GL 4462, VdTÜV 04368

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	660 MPa (96 ksi)	857 MPa (124 ksi)	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-30 °C (22 °F)	41 J (30 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.03	0.8	0.8	8.8	23.2	3.2	0.16	42

Deposition Data

Diameter	Current	Voltage	Efficiency (%)
2 mm (5/64 in.)	30-65 A	29 V	0-108 %
2.5 mm (3/32 in.)	50-90 A	27 V	0-108 %
3.2 mm (1/8 in.)	80-120 A	28 V	0-108 %
4 mm (5/32 in.)	100-160 A	29 V	0-108 %
5 mm (3/16 in.)	150-220 A	30 V	0-108 %

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