

OK 68.17

Type Rutile-basic

SMAW

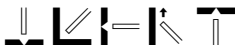
E410NiMo-16

Description

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.

Welding current

DC+, AC OCV 55 V



Typical all weld metal hardness

As welded:	36 HRC
	After PWHT:
600 °C/ 1h	29 HRC
600 °C/ 8h	25 HRC

Classifications

EN 1600	E 13 4 R 3 2
SFA/AWS A5.4	E410NiMo-16
Werkstoff Nr.	1.4351

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	0.8	11.8	4.5	0.6	<0.3

Typical mech. properties all weld metal

	PWHT (600 °C/ 8h)
Yield stress, MPa	650
Tensile strength, MPa	870
Elongation A5, %	17

Charpy V

Test temps, °C	Impact values, J
+20	45
-10	45
-40	40

Approvals

UDT	EN 1600
-----	---------

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.5	350	55-100	21	0.62	72.5	0.8	61
3.2	350	65-135	21	0.59	44.8	1.2	66
4.0	450	90-190	24	0.59	22.7	1.7	92