

# OK 68.82

Type Acid-rutile

SMAW  
(E312-17)

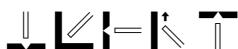
## Description

OK 68.82 is a high-alloyed electrode which deposits a ferritic-austenitic duplex weld metal with approx. 30-35% ferrite. It is resistant to stress corrosion and is highly insensitive to dilution.

Good scaling resistance up to 1150°C. OK 68.82 is used for joining steels with reduced weldability and buffer layers prior to hard surfacing, dissimilar steels, rolls, aluminium-forging dies, hot-work tools, dies for plastic and so on.

## Welding current

DC+, AC OCV 55 V



## Classifications

EN 1600 E 29 9 R 1 2  
SFA/AWS A5.4 (E312-17)  
Werkstoff Nr. 1.4337

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	1.0	0.9	29.0	10.0	<0.5	<0.3

## Typical mech. properties all weld metal

Yield stress, MPa 500  
Tensile strength, MPa 750  
Elongation A5, % 25

## Charpy V

Test temps, °C Impact values, J

Ferrite content FN 50-80

## 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 elec- trodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.0	300	30-60	26	0.54	166	0.7	33
2.5	300	60-90	25	0.52	104	1.0	45
3.2	350	80-120	26	0.52	55	1.3	57
4.0	350	110-170	30	0.55	36	2.0	60
5.0	350	140-230	30	0.55	22	2.7	71