

OK 67.13

Type Basic-rutile

SMAW

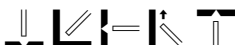
E310-16

Description

OK 67.13 is an austenitic, stainless-steel electrode for welding 25Cr20Ni steels. The weld metal resists scaling up to 1100-1150°C and does not contain any measureable ferrite. OK 67.13 can also be used for welding certain air-hardening steels such as armour plate and for welding stainless to unalloyed steel.

Welding current

DC+, AC OCV 65 V



Classifications

EN 1600	E 25 20 R 1 2
SFA/AWS A5.4	E310-16
Werkstoff Nr.	1.4842

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Cu
0.12	0.5	2.0	26.0	21.0	<0.2

Typical mech. properties all weld metal

Yield stress, MPa	560
Tensile strength, MPa	600
Elongation A4, %	35

Charpy V

Test temps, °C	Impact values, J
+20	60

Ferrite content	FN 0
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Approvals

UDT	EN 1600
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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	300	60-85	21	0.51	101.0	0.8	42
3.2	350	80-120	24	0.51	53.0	1.2	58
4.0	350	105-160	28	0.51	34.0	1.7	61
5.0	350	150-220	31	0.54	20.5	2.6	67