

OK 67.15

Type Lime-basic

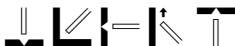
SMAW
E310-15

Description

OK 67.15 is a stainless-steel electrode for welding 25Cr20Ni steels. It is also suitable for welding armour steel, austenitic-manganese steel and for joining dissimilar steels. OK 67.15 deposits a very crack-resistant weld metal.

Welding current

DC+



Classifications

EN 1600	E 25 20 B 2 2
SFA/AWS A5.4	E310-15
Werkstoff Nr.	1.4842

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	0.5	2.2	26.0	21.0	<0.5	<0.5

Typical mech. properties all weld metal

Yield stress, MPa	410
Tensile strength, MPa	590
Elongation A5, %	35

Charpy V

Test temps, °C	Impact values, J
+20	100

Ferrite content	FN 0
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Approvals

DB	30.039.01
Sepros	UNA 409820
SS	EN 1600
UDT	EN 1600
VD TÜV	01025
Ü	30.039

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
2.0	300	35-55	24	0.62	162	0.6	36
2.5	300	55-85	25	0.61	96	0.9	40
3.2	350	70-110	25	0.59	50	1.2	60
4.0	350	110-150	26	0.59	28	1.8	62
5.0	350	150-200	26	0.60	22	2.5	65