

# OK 67.55

Type Basic

SMAW

E2209-15

## Description

OK 67.55 is a basic coated electrode specially designed for the welding of duplex stainless steel, e.g. UNS S31803. The deposited weld metal gives very high ductility down to -50°C/-60°C. Particularly suitable for welding duplex pipes in offshore applications.

## Welding current

DC+



## Classifications

EN 1600	E 22 9 3 N L B 2 2
SFA/AWS A5.4	E2209-15
Werkstoff Nr.	1.4462

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	N
<0.04	0.5	0.9	22.5	9.3	3.0	0.15

## Typical mech. properties all weld metal

Yield stress, MPa	650
Tensile strength, MPa	800
Elongation A5, %	28

## Charpy V

Test temps, °C	Impact values, J
+20	100
-20	85
-40	75
-60	65
Ferrite content	FN 35-50

## Approvals

DNV	For duplex SS
Sepros	UNA 409820
UDT	EN 1600
VdTÜV	06774

## 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	50-80	21	0.58	98	0.8	46
3.2	350	60-100	21	0.58	50	1.0	71
4.0	350	100-140	21	0.58	32	1.5	74