

OK 67.75

Type Basic

SMAW

E309L-15

Description

OK 67.75 is a basic coated, stainless electrode for welding steels of the 24Cr13Ni type, for welding transition layers when surfacing mild steel with stainless, for joining dissimilar steels and welding root runs in the stainless side of clad steels.

Welding current

DC+



Classifications

EN 1600	E 23 12 L B 4 2
SFA/AWS A5.4	E309L-15
Werkstoff Nr.	1.4332

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.04	0.5	2.2	24.0	13.0	<0.5	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	470
Tensile strength, MPa	600
Elongation A4, %	35

Charpy V

Test temps, °C	Impact values, J
+20	75
-80	55

Ferrite content FN 12-22

Approvals

ABS	Stainless
DNV	309
LR	SS to C/Mn Steels
Sepros	UNA 409820
UDT	EN 1600
VdTÜV	00633

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	22	0.73	78.0	1.1	42
3.2	350	80-110	24	0.73	39.0	1.5	60
4.0	350	100-150	26	0.73	25.0	2.3	62
5.0	350	160-220	27	0.73	16.5	3.4	65