

OK 68.25

Type Basic

SMAW

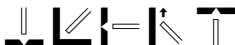
E410NiMo-15

Description

OK 68.25 is an electrode for welding corrosion-resistant, martensitic and martensitic-ferritic rolled, forged and cast steels, such as castings of 13Cr4NiMo type.

Welding current

DC+



Classifications

EN 1600	E 13 4 B 4 2
SFA/AWS A5.4	E410NiMo-15
ISO 3581	E 13.4 B
Werkstoff Nr.	1.4351

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo
<0.04	0.5	0.8	12.0	4.5	0.6

Typical mech. properties all weld metal

	PWHT 600°C/8h
Yield stress, MPa	680
Tensile strength, MPa	880
Elongation A5, %	17

Charpy V

Test temps, °C	Impact values, J
+20	60
0	56
-20	53

Approvals

Sepros	UNA 409820
UDT	EN 1600

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
3.2	450	90-150	28	0.64	34.5	1.6	63
4.0	450	110-190	28	0.66	21.6	2.2	73
5.0	450	140-250	27	0.67	13.7	3.1	86