

OK 68.55

SMAW

Type Basic

E 25 9 4 N L B 4 2

Description

OK 68.55 is a basic coated electrode for welding austenitic-ferritic steels of the Super Duplex type, e. g. SAF 2507 and Zeron 100. OK 68.55 deposits a weld metal with high ductility.

Welding current

DC+



Corrosion data

ASTM A-262

Practice B: 0.24mm/year

Practice C: 0.20mm/year

NACE TM 01-77:

Stress level: 770 MPa

Time to fracture (h): >720

ASTM G48-76: 60°C

Classifications

EN 1600 E 25 9 4 N L B 4 2
Werkstoff Nr. (1.4410)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	N
<0.04	0.5	0.8	25.3	9.8	4.0	0.25

Typical mech. properties all weld metal

Yield stress, MPa 700

Tensile strength, MPa 900

Elongation A5, % 28

Charpy V

Test temps, °C Impact values, J

+20 90

-20 70

-40 55

-60 45

Ferrite content FN 35-50

Approvals

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
2.5	300	50-80	23	0.62	93	0.8	48
3.2	350	60-100	23	0.63	46	1.1	68
4.0	350	100-140	23	0.62	32	1.6	70