

OK 67.45

Type Lime-basic

SMAW
(E307-15)

Description

Austenitic stainless steel electrode producing a weld metal with less than 5% ferrite. The tough weld metal has excellent crack resistance, even when welding steels with very poor weldability. Suitable for joining 12 -14% manganese steel to itself or other steels.

It is also suitable for buffer layers before hardfacing.

Welding current

DC+



Classifications

EN 1600 E 18 8 Mn B 4 2
SFA/AWS A5.4 (E307-15)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.11	0.5	6.0	18.5	8.5	<0.5	<0.5

Typical mech. properties all weld metal

Yield stress, MPa 470
Tensile strength, MPa 605
Elongation A5, % 35

Charpy V

Test temps, °C +20
Impact values, J 85

Ferrite content FN <5

Approvals

ABS Stainless
Sepros UNA 409820
UDT EN 1600
VdTÜV 01580

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	0.58	102	0.7	50
3.2	350	70-100	24	0.60	51	1.1	71
4.0	350	100-140	24	0.60	33	1.5	73
5.0	350	150-200	25	0.60	22	2.2	80