

# OK 67.53

Type Rutile

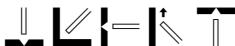
SMAW  
(E2209-16)

## Description

OK 67.53 is a rutile coated electrode designed for welding ferritic-austenitic duplex stainless steel pipes, e.g. UNS 31803 and 1.4462. The electrode has a thin coating which is ideal for root runs and positional welding.

## Welding current

DC+, AC OCV 55 V



## Classifications

EN 1600	E 22 9 3 N L R 1 2
SFA/AWS A5.4	(E2209-16)
Werkstoff Nr.	1.4462

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu	N
<0.03	0.9	0.9	23.0	9.5	3.3	<0.3	0.18

## Typical mech. properties all weld metal

Yield stress, MPa	660
Tensile strength, MPa	840
Elongation A5, %	25

## Charpy V

Test temps, °C	Impact values, J
+20	>40

Ferrite content	FN 25-40
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## Approvals

DNV	For duplex SS
UDT	EN 1600
VdTÜV	05422

## 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
2.0	265	25-60	24	0.64	170	0.5	41
2.5	300	30-80	23	0.63	96	0.7	54
3.2	350	70-110	25	0.57	51	1.3	56