

# OK 68.15

Type Lime-basic

SMAW

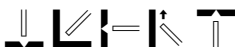
E410-15

## Description

OK 68.15 is a stainless-steel electrode which deposits a ferritic 13Cr weld metal. OK 68.15 is designed for welding steels of similar composition, when CrNi-alloyed austenitic stainless steel electrodes cannot be used, e.g. when the structure is going to be exposed to aggressive sulphuric gases. Depending on the welding parameters, the structure and consequently the mechanical properties of untreated weld metal can vary within fairly large limits.

## Welding current

DC+



## Classifications

EN 1600	E 13 B 4 2
SFA/AWS A5.4	E410-15
Werkstoff Nr.	1.4009

## Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.06	<0.7	<1.0	12.5	<0.6	<0.5	<0.2

## Typical mech. properties all weld metal

	PWHT 750 °C/ 1h
Yield stress, MPa	370
Tensile strength, MPa	520
Elongation A4, %	25

## Charpy V

Test temps, °C	Impact values, J
+20	55
0	35
-20	20

## 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
2.5	350	65-115	25	0.62	73	1.0	48
3.2	450	90-160	25	0.63	33	1.5	71
4.0	450	120-220	30	0.57	24	2.0	73
5.0	450	170-270	30	0.60	15	2.5	85