

OK 69.33

Type Basic-rutile

SMAW

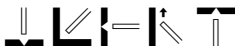
E385-16

Description

OK 69.33 is a stainless-steel electrode which deposits a fully austenitic weld metal with increased resistance to sulphuric acid. The weld metal of OK 69.33 also has good resistance to intergranular and pitting corrosion.

Welding current

AC, DC+ OCV 65 V



Classifications

EN 1600	E 20 25 5 Cu N L R 3 2
SFA/AWS A5.4	E385-16
Werkstoff Nr.	1.4519

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
<0.03	0.5	1.3	20.5	25.5	4.8	1.6

Typical mech. properties all weld metal

Yield stress, MPa	400
Tensile strength, MPa	575
Elongation A4, %	35

Charpy V

Test temps, °C	Impact values, J
+20	80
-140	45

Ferrite content	FN 0
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Approvals

Sepros	UNA 409820
UDT	EN 1600
VdTÜV	02723

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	300	40-60	23	0.58	125	0.7	40
2.5	300	60-85	24	0.60	91	0.9	44
3.2	350	85-130	27	0.58	41	1.5	60
4.0	350	120-180	29	0.51	30	1.9	64
5.0	350	160-240	31	0.51	19	2.5	78