

OK 68.81

High alloy stainless electrode of unusual versatility, giving a ferritic-austenitic duplex weld metal with an approximate ferrite content of FN 40. The weld metal is resistant to stress corrosion attack and highly insensitive to dilution by melted parent metal. Applications: joining of HWT steels, dissimilar steels, surfacing rails, rolls, alforjoring dies, hot work tools, dies for plastics etc. Good scaling resistance up to 1150 °C.

Classifications	EN 14700 : E Fe11 EN ISO 3581-A : E 29 9 R 3 2 SFA/AWS A5.4 : E312-17 Werkstoffnummer : 1.4337
Approvals	CE : EN 13479 Seproz : UNA 272580

Welding Current	DC+, AC
Ferrite Content	FN 30 - 50
Alloy Type	Stainless duplex
Coating Type	Acid Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	610 MPa	790 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C	30 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.13	0.9	0.7	10.2	28.9	0.04	0.09	40

Deposition Data						
Diameter	Current	Voltage	Efficiency (%)	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.0 x 300.0 mm	40-60 A	22 V	64 %	123	41 sec	0.7 kg/h
2.5 x 300.0 mm	50-85 A	24 V	64 %	78	48 sec	0.9 kg/h
3.2 x 350.0 mm	60-125 A	25 V	62 %	42	65 sec	1.3 kg/h
4.0 x 350.0 mm	80-175 A	26 V	62 %	26	66 sec	2.0 kg/h
5.0 x 350.0 mm	150-240 A	28 V	65 %	17	68 sec	3.2 kg/h