

OK 68.53

SMAW

Type Basic-rutile

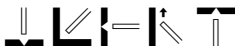
E 25 9 4 N L R 3 2

Description

OK 68.53 is a coated electrode for welding austenitic-ferritic steels of Super Duplex types, e.g. SAF 2507 and Zeron 100. OK 68.53 has good welding characteristics in all positions and the slag is easily detachable.

Welding current

DC+, AC OCV 60 V



Classifications

EN 1600 E 25 9 4 N L R 3 2
Werkstoff Nr. (1.4410)

Typical all weld metal composition, %

| C | Si | Mn | Cr | Ni | Mo | N |
|-------|-----|-----|------|-----|-----|------|
| <0.04 | 0.6 | 0.8 | 25.2 | 9.8 | 4.0 | 0.25 |

Typical mech. properties all weld metal

Yield stress, MPa 700
Tensile strength, MPa 850
Elongation A5, % 30

Charpy V

Test temps, °C Impact values, J
+20 50
-40 40

Ferrite content FN 35-50

Approvals

UDT EN 1600
VdTÜV 07377

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 | 55-85 | 22 | 0.60 | 94 | 0.9 | 43 |
| 3.2 | 350 | 70-110 | 22 | 0.60 | 47 | 1.2 | 62 |
| 4.0 | 350 | 110-150 | 23 | 0.60 | 32 | 1.7 | 67 |