

OK 68.82

Type Acid-rutile

SMAW

(E312-17)

Description

OK 68.82 is a high-alloyed electrode which deposits a ferritic-austenitic duplex weld metal with approx. 30-35% ferrite. It is resistant to stress corrosion and is highly insensitive to dilution. Good scaling resistance up to 1150°C. OK 68.82 is used for joining steels with reduced weldability and buffer layers prior to hard surfacing, dissimilar steels, rolls, aluminium-forging dies, hot-work tools, dies for plastic and so on.

Welding current

DC+, AC OCV 55 V



Classifications

EN 1600	E 29 9 R 1 2
SFA/AWS A5.4	(E312-17)
Werkstoff Nr.	1.4337

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu
0.12	1.0	0.9	29.0	10.0	<0.5	<0.3

Typical mech. properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	750
Elongation A5, %	25

Charpy V

Test temps, °C Impact values, J

Ferrite content FN 50-80

Approvals

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
2.0	300	30-60	26	0.54	166	0.7	33
2.5	300	60-90	25	0.52	104	1.0	45
3.2	350	80-120	26	0.52	55	1.3	57
4.0	350	110-170	30	0.55	36	2.0	60
5.0	350	140-230	30	0.55	22	2.7	71