

OK 67.13

OK 67.13 is an austenitic stainless steel electrode depositing a 25Cr-20Ni type weld deposit, which has excellent stability and oxidation resistance in continuous service up to 1100°C.

Specifications

Classifications	SFA/AWS A5.4 : E310-16
Approvals	CE : EN 13479 UKCA : EN 13479

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	AC, DC+
Ferrite Content	0 FN
Alloy Type	Austenitic Cr-Ni
Coating Type	Rutile

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	430 MPa	600 MPa	34 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	20 °C	90 J
ISO		
As Welded	20 °C	83 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.10	1.70	0.60	21.00	26.50

Deposition Data

Diameter	Current
2.5 x 350 mm	60-100 A
3.15 x 350 mm	70-100 A
4.0 x 350 mm	120-170 A