

## OK 67.45

OK 67.45 is an austenitic stainless steel electrode giving a weld metal of the 20Cr-10Ni-5Mn type. The tough weld metal imparts excellent crack resistance, when welding steels of even poor weldability.

| Specifications  |                                                                      |
|-----------------|----------------------------------------------------------------------|
| Classifications | SFA/AWS A5.4 : E307-16 (Nearest)                                     |
| Approvals       | ABS : Stainless<br>CE : EN 13479<br>UKCA : EN 13479<br>VdTÜV : 01580 |

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

|                 |                     |
|-----------------|---------------------|
| Welding Current | AC, DC+             |
| Alloy Type      | Austenitic Cr-Ni-Mn |
| Coating Type    | Rutile              |

| Typical Tensile Properties |                |                  |            |
|----------------------------|----------------|------------------|------------|
| Condition                  | Yield Strength | Tensile Strength | Elongation |
| AWS                        |                |                  |            |
| As Welded                  | 450 MPa        | 610 MPa          | 45 %       |

| Typical Charpy V-Notch Properties |                     |              |
|-----------------------------------|---------------------|--------------|
| Condition                         | Testing Temperature | Impact Value |
| ISO                               |                     |              |
| As Welded                         | 20 °C               | 85 J         |
| As Welded                         | -60 °C              | 50 J         |

| Typical Weld Metal Analysis % |      |      |       |       |      |
|-------------------------------|------|------|-------|-------|------|
| C                             | Mn   | Si   | Ni    | Cr    | Mo   |
| 0.04                          | 5.10 | 0.60 | 10.50 | 20.50 | 0.60 |

| Deposition Data |           |
|-----------------|-----------|
| Diameter        | Current   |
| 2.5 x 300 mm    | 60-100 A  |
| 3.15 x 350 mm   | 70-100 A  |
| 4.0 x 350 mm    | 120-170 A |
| 5.0 x 350 mm    | 160-210 A |