

OK 67.67

OK 67.67 is a rutile based, all positional electrode depositing a weld metal of the type 23Cr-13Ni. The weld deposit provides excellent resistance to corrosion and oxidation at very high temperatures, up to 1100°C.

Specifications	
Classifications	SFA/AWS A5.4 : E309/E309H-16

Welding Current	AC, DC+
Ferrite Content	5-15 FN
Alloy Type	Austenitic Cr-Ni
Coating Type	Rutile

Typical Tensile Properties				
Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
AWS				
As Welded	As welded	480 MPa	590 MPa	35 %

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Cr
0.05	0.70	0.75	13.20	23.50

Deposition Data	
Diameter	Current
2.5 x 350.0 mm	60-100 A
3.15 x 350.0 mm	80-120 A
4.0 x 350.0 mm	120-170 A