

OK 67.50

OK 67.50 is an acid rutile coated type for welding of austenitic-ferritic stainless steels of CrNiMoN 22 5 3 - and CrNiN 23 4-types. The duplex all weld metal offers a high strength level combined with good ductility. The pitting corrosion resistance is good and the all weld metal is not sensitive for stress corrosion cracking.

Specifications	
Classifications	EN ISO 3581-A : E 22 9 3 N L R 3 2 SFA/AWS A5.4 : E2209-17 CSA W48 : E2209-17 Werkstoffnummer : 1.4462
Approvals	ABS : Stainless* BV : 2209 CE : EN 13479 CWB : CSA W48: E2209-17 DNV-GL : Duplex RINA : 2209 Sepro : UNA 272580 VdTÜV : 04368

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

Welding Current	AC, DC+
Ferrite Content	35-50 FN
Alloy Type	Duplex CrNiMoN
Coating Type	Acid Rutile

Typical Tensile Properties				
Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
ISO				
As Welded	As welded	691 MPa	857 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C	50 J
As Welded	-30 °C	41 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.03	0.8	0.8	8.8	23.2	3.2	0.16	42

Deposition Data	
Diameter	Current
2.0 x 300 mm	30-65 A
2.5 x 300 mm	50-90 A
3.2 x 350 mm	80-120 A
4.0 x 350 mm	90-160 A
5.0 x 350 mm	150-220 A