

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 CE : EN 13479 UKCA : EN 13479 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