

OK 68.00

OK 68.00 is a rutile coated stainless steel electrode for the welding of stainless steel castings of the 13Cr4NiMo type.

Specifications

Classifications	SFA/AWS A5.4 : E410NiMo-26
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Welding Current	AC, DC+
Alloy Type	Martensitic 12Cr-4.5Ni-0.5Mo
Coating Type	Rutile

Typical Tensile Properties

Condition	Conditional Statement	Tensile Strength	Elongation
AWS			
Stress Relieved	PWHT 610°C 1h	800 MPa	16 %

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo
0.05	0.55	0.40	4.75	12.00	0.55

Deposition Data

Diameter	Current
3.15 x 350.0 mm	90-120 A
4.0 x 350.0 mm	120-170 A