

OK 67.55

Basic coated electrode especially designed for welding duplex stainless steels i.e. UNS S31803. Suitable for applications where the requirements on the mechanical properties are high.

Specifications	
Classifications	EN ISO 3581-A : E 22 9 3 N L B 2 2 SFA/AWS A5.4 : E2209-15 Werkstoffnummer : 1.4462
Approvals	DNV-GL : Duplex VdTÜV : 06774

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

Welding Current	DC+
Ferrite Content	FN 35-50
Alloy Type	Austenitic CrNiMo
Coating Type	Basic

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	650 MPa	800 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	-20 °C	85 J
As Welded	-60 °C	65 J
As Welded	20 °C	100 J
As Welded	-40 °C	75 J

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.04	1.0	0.7	9.1	23.2	3.2	0.15	41

Deposition Data					
Diameter	Current	Voltage	Deposition Efficiency (%)	Fusion time per electrode at 90% I max	Deposition Rate @ 90% I max
2.5 x 300.0 mm	50-80 A	23 V	59 %	49 sec	0.8 kg/h
3.2 x 350.0 mm	65-115 A	24 V	59 %	61 sec	1.2 kg/h
4.0 x 350.0 mm	80-140 A	24 V	60 %	74 sec	1.5 kg/h