

OK 67.63

OK 67.63 is a rutile based, low carbon all positional electrode of 23Cr-13Ni type for joining of stainless steels to unalloyed or low alloyed steels. Also suitable for transition layers when surfacing mild or low alloyed steels with stainless steel weld metal.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 L R 32 SFA/AWS A5.4 : E309L-16
Approvals	CE : EN 13479 NAKS/HAKC : 2.5-4.0mm PDIL : E309L-16

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

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	490 MPa	600 MPa	40 %

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Cr
0.025	0.85	0.75	13.60	23.00

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
5.0 x 350.0 mm	160-210 A