

## OK 68.55

Stainless MMA electrode for welding austenitic-ferritic stainless steels of the so called "Superduplex-type", e.g. SAF 2507 and Zeron 100.

### Specifications

<b>Classifications</b>	EN ISO 3581-A : E 25 9 4 N L B 4 2 SFA/AWS A5.4 : E2594-15 Werkstoffnummer : (1.4410)
<b>Approvals</b>	DNV-GL : Duplex

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

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

### Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
<b>ISO</b>				
As Welded	As welded	700 MPa	900 MPa	28 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>ISO</b>		
As Welded	-20 °C	70 J
As Welded	20 °C	90 J
As Welded	-60 °C	45 J
As Welded	-40 °C	55 J

### Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr	Mo	N	FN WRC-92
0.03	0.9	0.6	10.4	25.2	4.3	0.23	45

### Deposition Data

Diameter	Current
2.5 x 300 mm	50-80 A
3.2 x 350 mm	60-100 A
4.0 x 350 mm	100-140 A