OK 67.75

OK 67.75 is a basic coated, stainless electrode for welding steels of the 24Cr13Ni type, for welding transition layers when surfacing mild steel with stainless, for joining dissimilar steels and welding root runs in the stainless side of clad steels.

Classifications	SFA/AWS A5.4 : E309L-15 EN ISO 3581-A : E 23 12 L B 4 2 Werkstoffnummer : 1.4332
Approvals	ABS Stainless CE EN 13479 DNV-GL VL 309 LR SS/CMn NAKS/HAKC 2.5-5.0 mm Seproz UNA 272580 VdTÜV 00633

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

Welding Current	DC+
Ferrite Content	FN 8-15
Alloy Type	Austenitic CrNi
Coating Type	Basic

Typical Tensile Properties

Yield Strength	Tensile Strength	Elongation
470 MPa (68.2 ksi)	600 MPa (87 ksi)	35 %

Typical Charpy V-Notch Properties

Testing Temperature	Impact Value
20 °C (68 °F)	75 J (55 ft-lb)
-50 °C (-58 °F)	64 J (47 ft-lb)
-80 °C (-112 °F)	55 J (40.5 ft-lb)

Deposition Data

Diameter	Current	Voltage	kg weld metal/kg electrodes	Number of electrodes/ kg weld metal	Fusion time per electrode at 90% I max	Deposition Rate
2.5 x 300 mm (3/32 x 12 in.)	50-80 A	22 V	0.73	78	42 sec	1.1 kg/h (2.4 lb/h)
3.2 x 350 mm (1/8 x 14 in.)	80-110 A	24 V	0.73	39	60 sec	1.5 kg/h (3.3 lb/h)
4.0 x 350 mm (5/32 x 14 in.)	80-150 A	26 V	0.73	25	62 sec	2.3 kg/h (5.1 lb/h)
5.0 x 350 mm (3/16 x 14 in.)	160-220 A	27 V	0.73	17	65 sec	3.4 kg/h (7.5 lb/h)

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