OK 68.10

A basic coated stainless steel electrode for depositing a ferritic weldmetal

Print

Classification AWS A5.4: E 410-15
IS 5206: E 13 B 20
DIN 8556: E 13 MBP 20+ 120

DESCRIPTION

OK 68.10 is a basic coated stainless steel electrode giving ferritic weldmetal of 13% Cr type for welding of ferritic-martensitic chrome steels, when Cr Ni alloyed austenitic stainless steel electrodes cannot be used e.g. when the construction will be exposed to aggressive sulphuric gases. OK 68.10 has excellent welding characteristics in all positions. It welds with a smooth and stable arc and the slag system design allows good wetting and washing to obtain a very finely rippled bead and a slag that is very easily detachable.

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

OK 68.10 is suitable for joining, surfacing, inlay and overlay applications on similar type of steels e.g. 410, 410S etc. Typical applications include machine parts, gears, fasteners, propeller shafts, welding of cast parts in gas turbine construction, welding of similar corrosion resistant chrome steels and steel castings, pump parts components in oil refineries, coal washers, rebuilding of valves, etc.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.07	Mn	0.7	YS	390 N/mm^2
Si	0.5	Ni	0.5	UTS	500 N/mm^2
Cr	13.5	Mo	0.20	EL (L=4d)	22%
S	0.017	P	0.019		

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	70-100	80	400
3.15	350	90-130	60	300
4.00	350	120-170	40	200
5.00	350	150-220	25	125

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box.