

# OK 67.13

## A basic rutile, 25 Cr, 20 Ni type austenitic stainless steel electrode



Classification      AWS A 5.4: E 310-16  
                               IS 5206: E 25.20 R 26  
                               DIN 8556: E 25 20 B20

### DESCRIPTION

OK 67.13 is a medium heavy coated, semi basic type austenitic stainless steel electrode depositing a 25 Cr, 20 Ni type weld deposit which has excellent stability and oxidation resistance in continuous service upto 1100°C. OK 67.13 has excellent striking and restriking properties and do not run the problem of short-circuiting during welding. The very smooth and quite arc in all positions coupled with a slag cover that is self-detaching and a weldbead finely rippled and shiny contributes to its immense welder appeal. The weldbead is of radiographic quality.

**APPROVALS:** RDSO

**WELDING CURRENT:** DC +, AC 65V

### TYPICAL APPLICATIONS

OK 67.12 is used for the welding of heat resisting steels of 25 Cr / 20 Ni type such as AISI 310 and Din werkst. Nr 1.4848, 1.4841, 1.4845, German steels like 4762, 4828, 4841, 4846 and 4848, cladding side of clad stainless steels, hydrogenation plants, polymerisation plants, gas turbine combustion chamber components, high temperature furnace parts, annealing boxes, carburising pots, armour plates and welding stainless steels to unalloyed steels.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.10	Si	0.50	UTS	580 N/mm <sup>2</sup>
Cr	26.0	S	0.015	YS	430 N/mm <sup>2</sup>
Ni	21.0	P	0.020	EL (L=4d)	35%
Mn	1.70			FERRITE	NIL

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	60-90	80	400
3.15	350	80-120	60	300
4.00	350	120-170	40	200
5.00	350	150-240	25	125

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