OK 67.45

A basic coated stainless steel electrode of the 18Cr-8Ni-6Mn type

Print

Classification AWS A 5.4: E 307-15 (Nearest)
DIN 8555: E 18 8 Mn B 20

DESCRIPTION

OK 67.45 is a basic coated austenitic stainless steel electrode giving a weldmetal of the 18 Cr-8 Ni-6 Mn type. The tough weldmetal imparts excellent crack resistance, when welding steels of even poor weldability. OK 67.45 has excellent arc and current carrying characteristics in all positions giving a very smooth, quite, stable arc and very little spatter. The slag system is fluid but controllable, giving a slag cover that is self-peeling and a weldbead that is smooth, even and shiny. The weld is of radiographic quality.

APPROVALS: CQA (Met), Khapore

WELDING CURRENT: DC+ AC 70V

TYPICAL APPLICATIONS

OK 67.45 find extensive use for joining dissimilar steels, 13 Mn steels with reduced weldability and for cladding carbon steels. OK 67.45 can also be used as a buffer layer prior to hard surfacing.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.08	Ni	9.5	YS	430 N/mm^2
Mn	6.00	Si	0.5	UTS	650 N/mm^2
Cr	19.0	P	0.020	EL (L=4d)	40%
S	0.015			Impact (CVN) at + 20°C	120J

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	150-220	25	125

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