

A rutile based stainless electrode for welding Duplex Stainless Steels



Classification AWS A5.4: E 2209-17
 DIN 8556: E 22 9 3 LR 23
 PR EN1600 : E 22 93 LR 23

DESCRIPTION

OK 67.50 is an acid rutile electrode specially designed for welding of UNS31500, UNS31803 types of ferritic-austenitic stainless steels (popular known as “Duplex stainless steels”). The composition of weldmetal is designed to give mechanical and corrosion properties that fully comply with these grades e.g., high resistance to stress corrosion cracking and high yield strength. The arc and current carrying characteristics are in the best traditions of ESAB stainless steel electrodes of the highest standards coupled with its self-releasing slag and its outstanding weld bead finish makes OK 67.50 is preferred by welders the world over for welding of Duplex Steel.

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

OK 67.50 find extensive use in welding of duplex steels of the type UNS31500, UNS31803 which need high resistance to stress corrosion and high yield strength e.g. in the ship building industry, chemical industries etc. OK 67.50 may also be used for joining of Duplex steels to mild steels. Welding of duplex steels should be made with low heat input.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.028	S	0.016	YS	645 N/mm ²
Mn	0.80	Ni	9.0	UTS	800 N/mm ²
Cr	22.0	Si	0.8	EL (L=4d)	25%
N	0.15	Mo	3.0	Impact (CVN) at +20°C	50J
P	0.018				

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	Wt. of Electrode/box, kg
2.50	350	60-90	10.2
3.15	350	80-120	13.2
4.00	350	100-160	12.9
5.00	350	150-220	12.6

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