

OK 67.60



An extra low carbon, 23% Cr 12% Ni type stainless steel electrode



Classification AWS A 5.4: E 309L-16
IS 5206: E 23.12LR 26
DIN 8556: E 23 12 LR 23

DESCRIPTION

OK 67.60 is a rutile based, extra low carbon, all position electrode of 25/12 type for joining of stainless steel to mild steel and for surfacing of mild steel. The extra low carbon content prevents carbide precipitation and hence avoids intergranular cracking. The weld deposit has excellent corrosion and oxidation resistance in continuous service upto 1100°C. OK 67.60 welds with a very smooth and stable arc, with virtually no spatter and slag cover that is self-releasing. The final weldbead is very finely rippled and shiny. The weldmetal is of radiographic quality.

WELDING CURRENT: DC +, AC 50V

APPROVALS: PDIL

TYPICAL APPLICATIONS

OK 67.60 is essentially used for welding heat resistant straight chrome steels and Cr-Ni alloyed steels for e.g. AISI 309 type steels, for working temperatures upto 1000°C if sulphurous attack does not occur. It is especially useful for joining stainless to mild steel; Stainless steels to low alloy steels and for welding root runs in clad steels of 18/8 type. It is also used widely for surfacing of mild steel and for building up worn out parts for wear resistant steels.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.028	Mn	0.80	YS	470 N/mm ²
Cr	24.0	Si	0.75	UTS	590 N/mm ²
Ni	13.0	S	0.015	EL (L=4d)	35%
P	0.020				

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.