

# OK 68.00



## A rutile based stainless steel electrode for depositing 13 Cr/4 Ni/0.5 Mo type weldmetal



Classification    AWS A 5.4: E 410Ni Mo-16  
                          IS 5206: E 13 4 R 26  
                          DIN 8556: E 25 10 LN B

### DESCRIPTION

OK 68.00 is a specially designed rutile coated stainless steel electrode depositing 13 Cr, 4.5 Ni & 0.5 Mo weldmetal. It has excellent welding characteristics in flat, H-V positions and V-up position. The weldmetal provides very good resistance to corrosion, erosion and pitting. OK 68.00 has outstanding arc and current carrying characteristics with a quite and stable arc. The slag is easily detachable revealing a smooth, shiny and finely rippled bead.

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

### TYPICAL APPLICATIONS

OK 68.00 is a suitable electrode for joining, surfacing applications of hydel turbine blades, valve seat runners, high pressure vessels, paper plant equipment, welding of guide vans and runners, similar corrosion resisting chromium steels, steel castings and martensitic-ferritic stainless steel of similar types.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.03	Cr	12.0	YS	680 N/mm <sup>2</sup>
Mn	0.8	Mo	0.5	UTS	800 N/mm <sup>2</sup>
Si	0.5	S	0.015	EL (L=4d)	17%
Ni	4.5	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	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.