

# OK 68.55



## A basic coated stainless steel electrode for welding Super Duplex Stainless Steels

Classification     DIN 8556: E 25 10 4 LN B 20+  
                          PR EN 1600: E2599 LB 42



### DESCRIPTION

OK 68.55 is a basic coated electrode for welding austenitic-ferritic steels or the so-called "Super Duplex Steels" type. OK 68.55 deposits a weldmetal with high ductility that has very high resistance to pitting, crevice and stress corrosion cracking. OK 68.55 possess excellent welding characteristics in all positions providing a smooth and stable arc in all positions with very little spatter. The slag is self-peeling and the final weldbead is smooth, finely rippled and shiny.

**WELDING CURRENT:** DC +

### TYPICAL APPLICATIONS

OK 68.55 is especially designed for welding of the new range of super duplex stainless steels, such as SAF 2507, Zeron 100, Ferralium 255 UR 47 N, DP3 and similar steels which find increasing use for good corrosion resistance and high structural strength that are required compared to conventional stainless steel grades.

### TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.028	P	0.018	YS	700 N/mm <sup>2</sup>
Mn	0.9	Cr	25.5	UTS	900 N/mm <sup>2</sup>
Si	0.4	Mo	4.0	EL (L=4d)	30%
Ni	9.5	N	0.25	Charpy V Impact at -60°C	45J
S	0.015				

### CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	Wt. of electrode/box, kg
2.50	350	50-80	10.8
3.25	350	60-100	13.2
4.00	350	100-160	13.5
5.00	350	150-240	12.3

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