

OK 67.50

Type Acid-rutile

SMAW

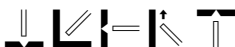
E2209-17

Description

OK 67.50 is a rutile coated electrode for welding ferritic-austenitic stainless steels, e.g. UNS S31803. Special applications include the welding of pipes with high resistance to stress corrosion up to 300°C, the so-called Duplex steels. OK 67.50 is particularly suitable for welding duplex cargo tanks.

Welding current

DC+, AC OCV 60 V



Classifications

EN 1600	E 22 9 3 N L R 3 2
SFA/AWS A5.4	E2209-17
Werkstoff Nr.	1.4462
CSA W48	E2209-17

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Cu	N
<0.03	0.7	0.9	22.3	9.5	3.0	<0.3	0.16

Typical mech. properties all weld metal

Yield stress, MPa	660
Tensile strength, MPa	820
Elongation A5, %	25

Charpy V

Test temps, °C	Impact values, J
+20	50

Ferrite content	FN 25-40
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Approvals

ABS	For welding duplex steels
BV	2209
CWB	CSA W48
DNV	For duplex SS
GL	4462
LR	S 31803
RINA	2209
Sepros	UNA 409820
UDT	EN 1600
VdTÜV	04368

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V	N. Kg weld metal/kg electrodes	B. No. of electrodes/kg weld metal	H. Kg weld metal/hour arc time	T. Burn-off time, s/ electrode
2.0	300	30-65	29	0.55	152	0.7	33
2.5	300	50-90	27	0.58	91	1.0	38
3.2	350	80-120	28	0.58	47	1.4	55
4.0	350	100-160	29	0.58	32	1.9	59
5.0	350	150-220	30	0.58	20	2.8	64