

OK 67.15



Basic coated MMA-electrode for welding 25Cr 20Ni-steels. Also suitable for welding armour steels, austenitic manganese steels and for joining of dissimilar steels.

Classifications:	Werkstoffnummer :1.4842, EN ISO 3581-A:E 25 20 B 2 2, SFA/AWS A5.4:E310-15
Approvals:	CE EN 13479, Seproz UNA 272580, DB 30.039.01, VdTÜV 01025

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Ferrite Content:	FN 0
Alloy Type:	Austenitic CrNi
Coating Type:	Lime Basic

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As welded	410 MPa	590 MPa	35 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
ISO		
As welded	20 °C	100 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni	Cr
0.10	2.0	0.4	21.3	25.7

Deposition Data

Diameter	Current	Voltage	kg weld metal/ kg electrodes	Number of electrodes/kg weld metal	Fusion time per electrode at 90% I max	Deposition rate 90% I max
2.0 x 300 mm	45-55 A	24 V	0.62	162	36 s	0.6 kg/h
2.5 x 300 mm	50-85 A	25 V	0.61	96	40 s	0.9 kg/h
3.2 x 350 mm	60-115 A	25 V	0.59	50	60 s	1.2 kg/h
4.0 x 350 mm	70-160 A	26 V	0.59	28	62 s	1.8 kg/h
5.0 x 350 mm	130-200 A	26 V	0.60	22	65 s	2.5 kg/h